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(21) International Application Number: PCT/US96/13683 (22) International Filing Date: 23 August 1996 (23.08.96) (30) Priority Data: 60/002,756 24 August 1995 (24.08.95) US (60) Parent Application or Grant (63) Related by Continuation US 60/002,756 (CON) Filed on 24 August 1995 (24.08.95) (71) Applicant (for all designated States except US): THE DOW CHEMICAL COMPANY [US/US]; 2030 Dow Center, Ab- bott Road, Midland, MI 48640 (US). (72) Inventors; and (75) Inventors/Applicants (for US only): TASSET, Emmett, L. [US/US]; 111 White Oak Drive, Lake Jackson, TX 77566 (US). WEHMEYER, Richard, M. [US/US]; 205 Zinnia, Lake Jackson, TX 77566 (US). (74) Agent: WINKELMAN, Michael, L.; The Dow Chemical Company, Patent Dept., P.O. Box 1967, Midland, MI 48641- 1967 (US).		(81) Designated States: CA, CN, CZ, JP, US, European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE). Published With international search report.
(54) Title: ISOMERIZATION OF BISPHENOLS (57) Abstract <p>A catalyst useful for the condensation of an aldehyde or ketone starting material with a phenol was an insoluble mercaptosulfonic acid compound. The heterogeneous catalysts comprise catalytically-active species represented by formula (II). L was an optional linking group and - was a bond, which catalytically-active species was attached by the bond - to an insoluble organic or inorganic support; or a catalytically-active species represented by formula (III), wherein L' was an optional linking group, - was a bond and θ' and θ'' were residues of θ, and a and b were independently selected from integers equal to or greater than 1. These catalysts isomerize o,p-bisphenols to p,p-bisphenols.</p> <div style="text-align: center;"> $\begin{array}{c} (\text{HS})_a - \theta' - (\text{SO}_3\text{H})_b \\ \\ \text{L} \\ \end{array} \quad (\text{II})$ </div> <div style="text-align: center;"> $\begin{array}{c} (\text{HS})_a \quad (\text{SO}_3\text{H})_b \\ \backslash \quad / \\ -[\theta'' - \text{L}']- \end{array} \quad (\text{III})$ </div>		

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ISOMERIZATION OF BISPHENOLS

This invention relates to preparation of polyphenols, more particularly to the preparation of polyphenols from ketones or aldehydes and phenols.

5 Acid-catalyzed condensation of phenols with aldehydes or ketones was well known. Acid catalysts include acidic ion exchange resin catalysts and soluble acid catalysts. Soluble acid catalysts can be, for example, hydrogen chloride, sulfuric acid, hydrochloric acid, phosphoric acid, hydrobromic acid, nitric acid, dimethyl sulfate, sulfur dioxide,
10 4-toluenesulfonic acid, boron trifluoride, alkanesulfonic acids, boron trifluoride complexes and other acid-acting compounds, including compounds which were hydrolyzed by water to form acids; for example, aluminum chloride, sulfonyl chloride and phosgene.

15 A number of compounds were known to promote such an acid-catalyzed condensation. These promoters include mercaptan groups that were either free or bound to a resin. Alkyl mercaptans and bis-mercaptoethanolamine were examples of reported promoters.

 It has been proposed by Scriabine et al., (U. S. Patent No. 2,923,744) to produce Bisphenol A using sulfuric acid, promoted by
20 mercaptoalkanesulfonic acids or salts or corresponding sulfonate esters at a level of 0.1 to 5 percent by weight of the base charge, to catalyze condensation of acetone and phenols, when used in amounts of 0.1 to 5 percent by weight based on total charge. Sulfuric acid was used in amounts of 2 moles per mole of acetone.

25 Riemann et al., (U.S. Patent No. 4,675,458) have proposed making 9,9-bis-(4-hydroxyphenyl)fluorene in the presence of sulfuric acid, preferably concentrated sulfuric acid, and a mercaptan, particularly 3-mercaptopropionic acid, as a promoter.

30 Massirio et al., (U.S. Patent No. 5,248,838) have disclosed the use of a combination of methanesulfonic acid and a mercaptan/mercaptoalkanoic acid for catalyzing the condensation of phenols with fluorenone. High levels of methanesulfonic acid with respect to the feed and the mercaptan/mercaptoalkanoic acid, were used. The reactions can be run in halogenated hydrocarbon solvents.

35 Bottenbruch et al., (U. S. Patent No. 4,996,373) have proposed a process for producing dihydroxyaryl compounds from carbonyl compounds and

phenols under high pressure, in the presence of various catalysts, including sulfonic acid resins. Catalysts containing sulphydryl functionality, for example, ion exchangers treated with mercapto compounds, have been disclosed for this use.

5 Meyer et al., (U.S. Patent No. 4,387,251) have proposed processes for making 4,4'-dihydroxydiphenyl alkanes using aromatic sulfonic acids as condensing agents. Mercapto groups were included within the definition of R_3 and were characterized as being inert. Freitag et al., (U.S. Patent No. 5,210,328) disclose using the same types of sulfonic acid catalysts for
10 making cycloalkylidene bisphenols.

Jansen (U.S. Patent No. 2,468,982) has proposed preparation of bisphenols using anhydrous hydrogen chloride in combination with a mercaptoalkanoic acid, which may be formed *in situ* by reaction of a mercapton with the ketone, as condensing agent.

15 Knebel et al., (U.S. Patent No. 4,931,594) disclose the use of large amounts of sulfonic acid resin, mixed with uncombined 3-mercaptopropionic acid, to cause the condensation to occur.

It has been proposed in British Patent No. 1,185,223 to use a mixture of insoluble resins, one as a sulfonic acid resin and the other a
20 resin containing mercapto groups, for making bisphenols.

Randolph et al., (U.S. Patent No. 5,212,206) disclose a catalyst, made by treating a sulfonated ion-exchange resin with a dialkylaminomercaptan. Other references, representative of references on modification of sulfonic acid ion-exchange resins, include Wagner (U.S.
25 Patent No. 3,172,916). McNutt et al., (U.S. Patent No. 3,394,089), Faler et al., (U.S. Patent Nos. 4,455,409; 4,294,995 and 4,396,728); Heydenrich et al., (U.S. Patent No. 4,369,293); Berg et al., (U.S. Patent No. 5,302,774) and Maki et al., (U.S. Patent No. 4,423,252). The reactive catalysts generally include mercapto-functions attached to a sulfonic acid
30 group in the form of a sulfonamido or ammonium sulfonate salt.

Shaw (U.S. Patent No. 4,859,803) discloses preparing bisphenols from phenol and a ketone in the presence of an acidic (sulfonic acid) ion-exchange resin and a mercaptan. The mercaptan being added at particular locations of a specified reactor configuration to prevent the formation of
35 cyclic dimers.

Li has disclosed (U.S. Patent No. 4,825,010) isomerization of by-products of condensates of phenols and ketones, using a catalytic

amount of acidic sulfonated cationic-exchange resin having sulfonic acid sites ionically bonded to alkylmercaptoamines. Other patents by Li (U.S. Patent Nos. 4,822,923 and 5,001,281) further suggest the state of the art of using ion-exchange resins to isomerize by-products of bisphenol syntheses.

Powell et al., (U.S. Patent No. 5,105,026) disclose using acidic ion-exchange resins to isomerize undesirable products of bisphenol synthesis to desirable products, for example, to Bisphenol A. Morgan (U.S. Patent No. 3,546,165) has disclosed condensation of phenol with various ketones, including fluorenone and indanone, using high levels of hydrochloric acid or hydrogen chloride, in the presence of minor amounts of 3-mercaptopropionic acid. The products were used for the preparation of polyester resins.

Szabolcs (U.S. Patent Nos. 4,467,122 and 4,503,266) discloses washing crude product, containing BHPF, from a hydrochloric acid/zinc chloride catalyzed process, to remove HCl, ZnCl₂, and excess phenol, prior to recrystallization from dichloroethane. See also the abstract for DE OLS 2,948,222 (July 30, 1981).

Korshak et al., (SU 172,775) disclose washing a mixture of phenol, BHPF and HCl with water, after which phenol was removed by distillation.

The following references disclose the preparation of resins, containing sulfonic acid functionality, introduced either by copolymerization or by sulfonation after polymerization:

- U.S. Patent No. 3,205,285 Turbak et al.
- U.S. Patent No. 3,366,711 Mazzolini et al.
- U.S. Patent No. 3,426,104 Masson
- U.S. Patent No. 4,587,304 Thaler et al.
- U.S. Patent No. 4,764,557 Eichenauer et al.

Trapasso (U.S. Patent No. 3,706,707) discloses the preparation of adducts from a polymerized cyclic ether and a sultone. Dean (U.S. Patent No. 4,568,724) was of similar interest with respect to reaction products from an EPDM rubber and a sultone.

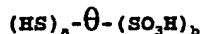
Welch (U.S. Patent No. 3,029,221) and Niwa et al., (U.S. Patent No. 4,912,170) disclose processes for modifying polystyrene resins.

It was an object of this invention to provide a process for the condensation of aldehydes or ketones with phenols, to achieve high yields

of preferred bis-(4-hydroxyaryl) isomers with low reaction times while avoiding use of strong inorganic acids.

Further objects of the invention include the development of processes for the synthesis of polyphenols, characterized by high yields of high purity products under reaction conditions, which were not corrosive to vessels in which the processes were conducted. In addition, avoiding the use of sulfuric acid, eliminates the possibility of side reactions, including sulfonation of phenols.

In one aspect, this invention relates to a process for the condensation of an aldehyde or ketone starting material with a phenol, unsubstituted in at least one position, comprising reacting the aldehyde or ketone starting material with the phenol in a reaction mixture in the presence of a soluble or insoluble mercaptosulfonic acid compound under conditions sufficient to bring about formation of a geminal bisphenolic moiety at each aldehyde or ketone moiety in the starting material; provided that the soluble mercaptosulfonic acid compound was characterized by the formula

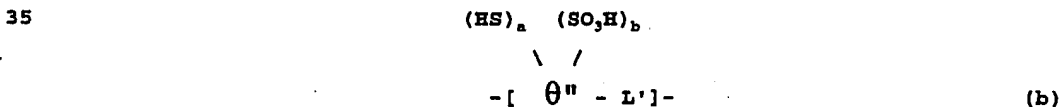


wherein θ was an alkylene, cycloaliphatic, arylene, alkylenearylene, alkylenecycloaliphatic, alkylenearyl, heterocyclic or alkyleneheterocyclic residue and a and b were independently selected from integers from 1 to 20; and

The insoluble mercaptosulfonic acid comprises a catalytically-active species represented by the formula



in which θ' was an alkylene, cycloaliphatic, arylene, alkylenearylene, alkylenecycloaliphatic, alkylenearyl, heterocyclic or alkyleneheterocyclic residue; a and b were independently selected from integers from 1 to 20; L was an optional linking group and - was a bond, which catalytically-active species was attached by the bond - to an insoluble organic or inorganic support; or a catalytically-active species represented by the unit formula



wherein θ'' was an alkylene, arylene, cycloaliphatic, alkylenearylene, alkylencycloaliphatic, alkylenearyl, heterocyclic or alkyleneheterocyclic residue; a and b were independently selected from integers from 1 to 20; L' was an optional linking group and - was a bond.

5 This invention further relates to novel catalytically-active polystyrene resins, characterized by bearing at least one of each of a mercapto-function and a sulfonic acid function on some individual styrene units of a polymer chain.

10 In yet another aspect, this invention relates to processes for preparing the catalytically-active polystyrene resins. These processes preferably comprise steps of (b) sulfonating a haloalkylpolystyrene to produce an intermediate having sulfo functional groups; (c) optionally converting the sulfo functional groups to corresponding alkali metal salts; (d) thiolating the thus-produced sulfostyrene intermediate by
15 reacting the halo function with a reactive thiolate to produce a corresponding mercapto group or precursor thereof; (e) optionally hydrolyzing the thus-thiolated intermediate with an acid or base when the thiolated group so requires and (f) optionally acidifying (if so required) to produce sulfonic acid functional groups units.

20 The process of the invention permits use of very low levels of a single acidic condensing agent. The process permits simplified product isolation procedures, recycle procedures, and/or waste management. The process does not require a neutralization step to remove hydrochloric or sulfuric acid and does not produce a waste salt stream. The acidic
25 condensing agents used in the process of this invention were readily removed from the reaction mixtures and can be recovered and recycled.

 The process of this invention results in high selectivity toward preferred bis-(4-hydroxyaryl) isomers and very fast reaction rates.

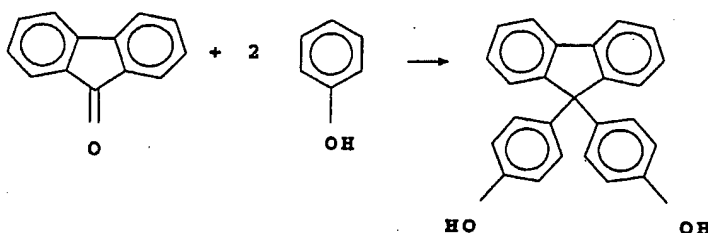
30 The process of this invention was particularly useful for the preparation of bis(hydroxyaryl) compounds, such as bisphenol A and 9,9-bis-(4-hydroxyphenyl)fluorene, both of which were useful in the preparation of polycarbonates and other commercially significant polymers.

 The heterogeneous catalysts disclosed herein advantageously were more reactive than heterogeneous catalysts currently used. They
35 advantageously allow using lower temperatures with correspondingly greater selectivity for desired product than was currently experienced. Greater selectivity reduces purification necessary to produce a desired or

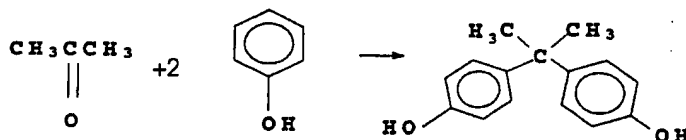
preselected purity of product. Thus, for a commercially produced bisphenol like bisphenol A, a heterogeneous catalyst disclosed herein can be advantageously substituted in an existing commercial process, run with the same or higher throughput at a lower temperature with less purification to achieve at least equally pure product.

Ketones or aldehydes and phenolic compounds (hereinafter phenol, phenols, a phenol or phenolic starting material) useful in process of the invention were known in the art and were described in the literature, for instance, Jansen '982, supra, Maki et al., '252, supra, Morgan '165, supra, and Knebel et al., '594, supra.

The condensations of this invention can be represented by the equation for a representative condensation, that of phenol with 9-fluorenone:



The process for making bisphenol A can be represented by the equation:



Phenol starting materials were advantageously any aromatic hydroxy compounds which have at least one unsubstituted position, and optionally have one or more inert substituents, such as hydrocarbyl or halogen at the one or more ring positions. An inert substituent was a substituent which does not interfere undesirably with the condensation of the phenol and ketone or aldehyde and which was not, itself, catalytic. Preferably, the phenols were unsubstituted in the position, para to the hydroxyl group.

Alkylene (alk), alkyl, cycloaliphatic, aryl, arylene (ar), alkyl-arylene (allkar), arylalkylene (aralk), alkylcycloaliphatic and alkylene-cycloaliphatic were hydrocarbyl functions, that was, functions containing carbon and hydrogen atoms. The alkylene functions can be straight-chain or branched-chain and saturated or unsaturated, that was alkylene, alkenylene, or alkynylene. Cycloaliphatic hydrocarbon residues include both saturated and unsaturated cyclic residues, that was, cycloalkylene and cycloalkenylene. Arylene includes mono- and polycyclic aromatic residues, for example, those of benzene, biphenyl, biaryl, naphthyl, phenanthrenyl, anthracenyl or aryl groups, including those bridged by an alkylene group. Alkaryl residues include alkyl, alkenyl and alkynyl-substituted aromatic rings. Aralkyl includes alkyl, alkenyl or alkynyl residues, substituted by one or more aromatic groups.

Alkyl groups include both straight-chain and branched-chain isomers of methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, nonyl, decyl, undecyl, dodecyl, tridecyl, tetradecyl, pentadecyl, hexadecyl, heptadecyl, nonadecyl and eicosyl groups, as well as the corresponding unsaturated (alkenyl or alkynyl) groups, as well as higher homologues. Preferably, the alkyl groups were of 1 to 20 carbon atoms, more preferably of 1 to 5 carbon atoms, most preferably those of 1 to 3 carbon atoms. Alkyl of 1 to 5 carbon atoms includes the various methyl, ethyl, propyl, butyl and pentyl isomers.

Alkyl, aryl, alkaryl and aralkyl substituents were suitable hydrocarbyl substituents on the phenol reactant.

Other inert substituents on the phenols include, but were not limited to alkoxy, aryloxy or alkaryloxy, wherein alkoxy includes methoxy, ethoxy, propyloxy, butoxy, pentoxy, hexoxy, heptoxy, octyloxy, nonyloxy, decyloxy and polyoxyethylene, as well as higher homologues; aryloxy, phenoxy, biphenoxy, naphthyloxy and alkaryloxy includes alkyl, alkenyl and alkynyl-substituted phenolics.

Additional inert substituents in phenols includes halo, such as bromo, chloro or iodo.

Cyano and nitro substituents may deactivate the phenols and aldehyde and carboxylic acid substituents may cause interfering reactions.

Additional hydroxyl substituents may be suitable in some cases.

Preferred substituents include alkyl moieties containing from 1 to 10 carbon atoms, more preferably, lower alkyl moieties, containing from 1

to 5 carbon atoms, most preferably from 1 to 3 carbon atoms. The alkyl substituents may be straight-chain or branched-chain isomers.

Exemplary phenols include, but were not limited to, phenol, 2-cresol, 3-cresol, 4-cresol, 2-chlorophenol, 3-chlorophenol, 4-chlorophenol, 2-tert-butylphenol, 2,4-dimethylphenol, 2-ethyl-6-methylphenol, 2-bromophenol, 2-fluorophenol, 2-phenoxyphenol, 3-methoxyphenol, 2,3,6-trimethylphenol, 2,3,5,6-tetramethylphenol, 2,6-xylenol, 2,6-dichlorophenol, 3,5-diethylphenol, 2-benzylphenol, 2,6-di-tertbutylphenol, 2-phenylphenol, 1-naphthol, 2-naphthol. Preferred phenols include phenol, 2- or 3-cresol, 2,6-dimethylphenol, resorcinol, naphthols, and mixtures thereof. Most preferably, the phenol was unsubstituted.

The ketones which were advantageously used include any ketone having a single ketone carbonyl (C=O) group or several ketone carbonyl groups, and which were reactive under the conditions used. The ketones can be substituted with substituents, which were inert under the conditions used. Inert substituents were as set forth above for the reactive phenols.

The ketones were advantageously selected from aliphatic, aromatic, alicyclic or mixed aromatic-aliphatic ketones, diketones or polyketones, of which acetone, methyl ethyl ketone, diethyl ketone, benzil, acetylacetone, methyl isopropyl ketone, methyl isobutyl ketone, acetophenone, ethyl phenyl ketone, cyclohexanone, cyclopentanone, benzophenone, fluorenone, indanone, 3,3,5-trimethylcyclohexanone, anthraquinone, 4-hydroxyacetophenone, acenaphthenequinone, quinone, benzoylacetone and diacetyl were representative examples.

Ketones having halo, nitrile or nitro substituents can also be used; for example, 1,3-dichloroacetone or hexafluoroacetone.

Aliphatic ketones which were useful starting materials include, but were not limited to acetone, ethyl methyl ketone, isobutyl methyl ketone, 1,3-dichloroacetone, hexafluoroacetone. A preferred aliphatic ketone was acetone, which condenses with phenol to produce 2,2-bis-(4-hydroxyphenyl)-propane, commonly known as bisphenol A. Another preferred aliphatic ketone was hexafluoroacetone, which reacts with two moles of phenol to produce 2,2-bis-(4-hydroxyphenyl)-hexafluoropropane (bisphenol AF).

A preferred class of ketones has at least one hydrocarbyl group containing an aryl group, for example, a phenyl, tolyl, naphthyl, xylyl or 4-hydroxyphenyl group.

Other preferred ketones include those in which the hydrocarbon radicals connected to the carbonyl groups of the ketone was in a cycloaliphatic group. Examples of specific preferred ketones include 9-fluorenone, cyclohexanone, 3,3,5-trimethylcyclohexanone, indanone, indenone, and anthraquinone.

Most preferred ketones include 9-fluorenone, benzophenone, acetone, acetophenone, 4-hydroxyacetophenone and 4,4'-dihydroxybenzophenone. Most preferably, the process of this invention was used to make bisphenol A by reaction of phenol with acetone or to make 9,9-bis-(4-hydroxyphenyl)fluorene (BHPPF) by reaction of phenol with 9-fluorenone.

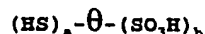
The process of this invention can also be used for the condensation of phenols with aldehydes; for example, with formaldehyde, acetaldehyde, propionaldehyde, butyraldehyde or higher homologues of the formula $RCHO$, wherein R was alkyl of 1 to 20 carbon atoms. The condensation of two moles of phenol with one mole of formaldehyde produces bis-(4-hydroxyphenyl)methane, also known as Bisphenol F.

It will be understood that dialdehydes and ketoaldehydes, for example, glyoxal, phenylglyoxal or pyruvic aldehyde, can also be used.

The products were generally geminal bisphenols, that was, compounds having one or more single carbon atoms to which were attached nuclei of two phenolic moieties. This single carbon atom corresponds to the carbonyl carbon of the ketone or aldehyde reactant. In the case of starting materials, containing more than one aldehyde or ketone carbonyl, the product will contain more than one geminal bisphenolic moiety. For example, the condensate from acetyl acetone and phenol was 2,2,4,4-tetrakis-(hydroxyphenyl)pentane and the condensate from benzoylacetone was 2,2,4,4-tetrakis-(hydroxyphenyl)-4-phenylbutane.

The mercaptosulfonic acid catalyst was any species, whether soluble or insoluble in the reaction mixture, containing at least one thiol (SH) group and at least one sulfonic acid (SO_3H) group, including any group which can be converted to a sulfonic acid group under the reaction conditions used.

In the specification and claims, the soluble mercaptosulfonic acid moiety was represented by the formula



wherein θ was an alkylene, cycloaliphatic, arylene, alkylenearylene, alkylencycloaliphatic, alkylenearyl, heterocyclic or alkyleneheterocyclic residue and each of "a" and "b" was independently an integer from 1 to 20.

5 "Soluble mercaptosulfonic acid," as used in the specification and claims, means a compound which has some solubility in the reaction mixture and which can be removed from the mixture, at the end of the reaction, by extraction, ion-exchange, precipitation, absorption.

"Insoluble mercaptosulfonic acid," as used in the specification and claims, means a material, which was insoluble in the reaction mixture.

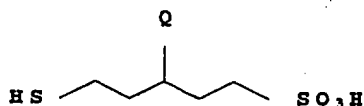
10 These materials were generally polymeric organic resins, or catalytically-active compounds, bonded to an inorganic support.

When θ was alkylene, the alkylene can be of 2 to 20 carbon atoms, including straight and branched chain alkylene moieties, corresponding heterochain moieties and alkylene substituted with inert substituents.

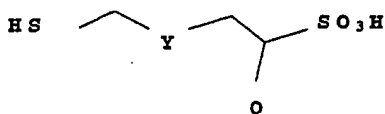
15 Inert substituents include, for example, alkoxy, alkenyl, alkynyl, halo, nitro, aryl.

Representative mercaptoalkanesulfonic acids include, but were not limited to, 2-mercaptoethanesulfonic acid, 3-mercaptopropanesulfonic acid, 4-mercaptobutanesulfonic acid, 4-mercaptopentanesulfonic acid, 3-mercapto-
20 2,2-dimethylpropanesulfonic acid, 2,3-dimercaptopropanesulfonic acid, mercaptopropane-2,3-disulfonic acid, 2-benzyl-4-mercaptobutanesulfonic acid, 5-mercaptopentanesulfonic acid. Most preferred among this group of catalysts were 3-mercaptopropanesulfonic acid and 4-mercaptobutanesulfonic acids.

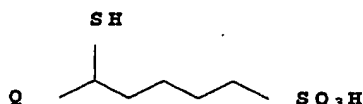
25 The types of mercaptoalkanesulfonic acids which were useable were exemplified by the following compounds of Formula I:



Formula I(a)



Formula I(b)



Formula I(c)

wherein Q was an inert substituent and Y was an optional heteroelement, for example O, N-Q or S. Q was H, hydrocarbyl, halo, carboxy, sulfonyl, as described above for inert substituents on the phenol, ketone or aldehyde starting materials. More than one Q may optionally be present.

5 The Q substituent can be at any position on the chain and more than one Q can be present. As set forth in the general formula for the soluble catalysts, more than one SH or sulfonic acid function were optionally present in the catalyst.

Compounds of Formula I(a) are included within the generic formula

10
$$\text{HS}(\text{CH}_2)_y\text{CH}(\text{Q})(\text{CH}_2)_z\text{SO}_3\text{H}$$

wherein y was an integer from 0 to 20, z was an integer from 0 to 20, Q was an optional inert substituent and $y + z \geq 1$, up to a maximum of 40.

Compounds of Formula I(b) are included within the generic formula

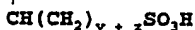
$$\text{HS}(\text{CH}_2)_y\text{-Y-(CH}_2)_z\text{SO}_3\text{H,}$$

15 wherein one or more inert substituents, Q, can be attached at any point along the carbon chain; wherein Y was a heteroelement, for example, -S-; each of y and z was at least 1 and $y + z \geq 2$, up to a maximum of 40.

Preferred linear mercaptoalkanesulfonic acids were those in which the distance between the mercapto and sulfonic acid functions were less than
20 20 atoms, including both carbon and heteroatoms. Compounds of Formula I(b) can also have more than one SH and/or more than one sulfonic acid function.

Compounds of Formula I(c) are included within the formula

HS



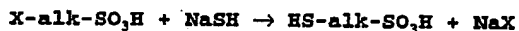
5

Q

wherein y and z were as above.

10 Mercaptosulfonic acid precursors can also be used as catalysts, by conversion to active mercaptosulfonic acid catalysts in the reaction mixtures. For example, a precursor alkali metal sulfonate salt can be neutralized with a mineral acid to produce a free sulfonic acid. Sulfonate ester precursors can be hydrolyzed by treatment with a strong base, for example, sodium or potassium hydroxide, and thus converted to a corresponding alkali metal salt. A further precursor of sulfonic acids for the practice of this invention, was a sulfonyl halide group, which can
15 readily converted to a corresponding sulfonic acid.

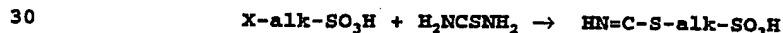
Mercaptosulfonic acids can be prepared from corresponding haloalkanesulfonic acids by reaction with an alkali metal mercaptide; for example,



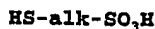
20 wherein X was Cl, Br or I and alk was alkylene, generally in accordance with Ellis et al., "The Preparation and Properties of a Double Series of Aliphatic Mercaptans," J. Am. Chem. Soc., Volume 54 (1932), Pages 1674-1687.

25 Alternatively, treatment of a haloalkanesulfonic acid with an alkali metal thioacetate, followed by hydrolysis, can be used to prepare mercaptoalkanesulfonic acids.

Another route to mercaptosulfonic acids was by converting halides to a corresponding thiouronium salt, which was hydrolyzed with a strong base, as follows:



35



generally according to Schramm et al., "The Synthesis of mercaptoalkanesulfonic Acids," J. Am. Chem. Soc., Volume 77 (1955), Pages
40 6231-6233.

Hydroxyalkanesulfonic acids can also be converted to the corresponding mercaptoalkanesulfonic acid by reaction with thiourea and HBr/HCl to produce a thiouronium salt, which was hydrolyzed using a strong base. See, Frank et al., "The Preparation of Mercaptans from Alcohols," J. Am. Chem. Soc., Volume 67 (1946), Pages 2103-2104.

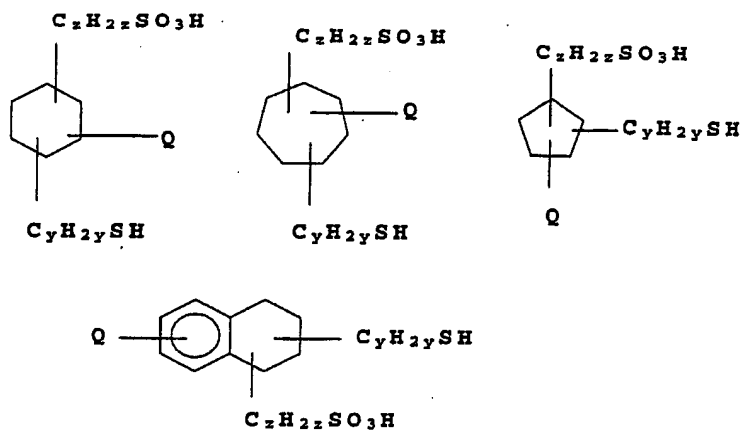
Higher mercaptoalkanesulfonic acids can be prepared from higher olefinsulfonic acids, for example, oleyl sulfonic acid, by adding hydrogen sulfide across the olefinic bond. Alternatively, the olefinic bond of an olefinic sulfonic acid can be halogenated, for example, chlorinated, and the halogen moiety replaced by a mercapto function, as above.

Mercaptoalkanesulfonic acids can also be made from corresponding sultones, for example, 1,4-butanedisulfone, in accordance with Chem. Abs., 90:86742m (1979); R. Fischer, "Propanedisulfone," Ind. Eng. Chem., Volume 56 (1964), Pages 41-45; or A. Mustafa, "The Chemistry of Sultones and Sultams," Chemical Reviews, Volume 54 (1954), Pages 195-223.

When - θ - was arylene, the sulfonic acid and mercapto moieties were attached directly to an aromatic ring. Representative aromatic mercaptosulfonic acids include 2-mercaptobenzenesulfonic acid, 3-mercaptobenzenesulfonic acid, 4-mercaptobenzenesulfonic acid, 2-mercaptonaphthalenesulfonic acid. The aromatic residues can be substituted with substituents, for example, H, alkyl, alkenyl, alkynyl, aryl, halo, alkoxy, aryloxy (Q, above), which were inert under the reaction conditions. The active catalysts can contain more than one SH and/or more than one sulfonic acid function in each molecule.

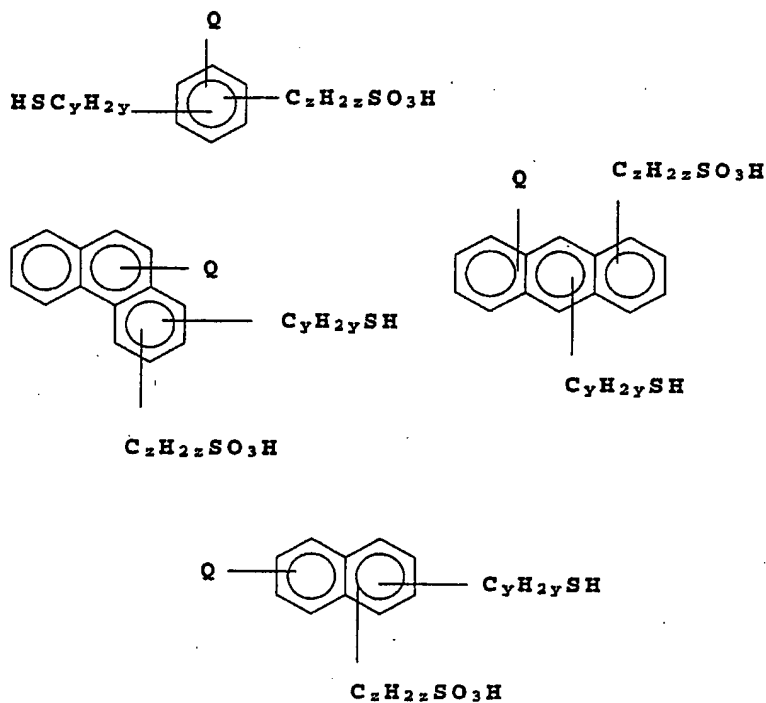
Cycloaliphatic residues include those of cyclohexane, cyclopentane and cycloheptane; the aliphatic ring of indane, Tetralin or benzocycloheptane. Representative cycloaliphatic mercaptosulfonic acids include, but were not limited to, 2-mercaptocyclohexanesulfonic acid, 2-mercaptocyclopentanesulfonic acid, 3-mercaptocyclohexanesulfonic acid, and 3-mercaptocyclopentanesulfonic acid. The cycloaliphatic rings can also be substituted with inert substituents and can contain more than one SH group and/or more than one sulfonic acid group.

Representative alkylencycloaliphatic mercaptosulfonic acid compounds can be represented by the following formulas:



wherein y and z were integers of 0 to 20; Q was an optional inert substituent selected from alkyl, aryl, halo, alkoxy or aryloxy and $y + z \geq 1$. Typical compounds include (mercaptomethyl)cyclohexanesulfonic acid and (mercaptomethyl)(sulfomethyl)cyclohexane.

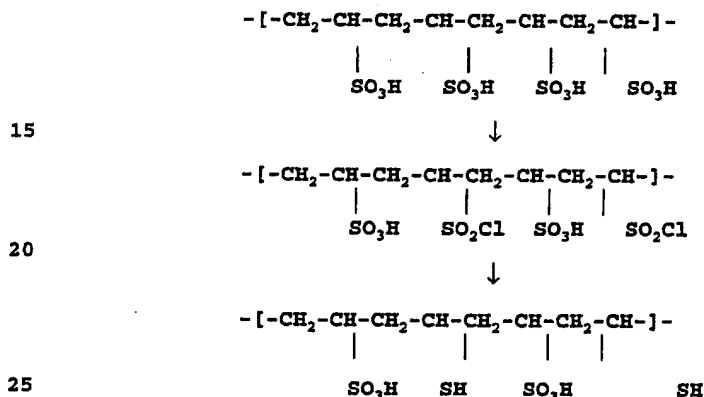
- 5 Typical alkylenearyl mercaptosulfonic acids can be represented by the formulas:



wherein x, y and Q were as above and $x + y \geq 1$.

A typical compound of this group, (mercaptomethyl)benzene-sulfonic acid, can be prepared from a corresponding chloromethyl- or bromomethylbenzenesulfonic acid.

5 Oligomers from vinylsulfonic acid can provide soluble materials, containing large numbers of mercapto and sulfonic acid groups. This type of soluble catalyst can be prepared from oligomers containing vinylsulfonic acid units, half of which can be converted to chlorosulfonyl units and reduced to mercapto units in accordance with the following
10 reaction scheme:



Another type of oligomeric catalysts, containing a multiplicity of mercapto and sulfonic acid units, can be prepared from propenesultone. Propenesultone was prepared as described by G. Manecke et al., Chem. Abs. 53:2083c (1959), Helberger et al., DE 1,146,870 and Chem. Abs. 59:11259
30 (1963). The sultone ring of the polymer can be opened, generally as above, to furnish mercaptosulfonic acid oligomers, containing a plurality of mercapto and sulfonic acid units.

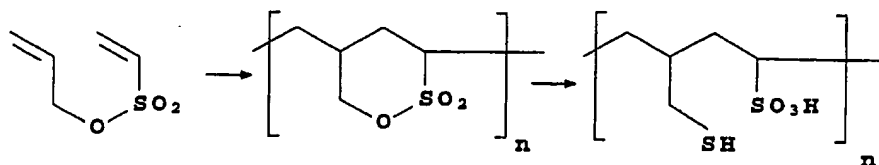
In addition, oligomers containing a plurality of mercaptosulfonic acid functions can be prepared from oligomers of 4-allyl-1,4-
35 butanesultone. The monomer was prepared as described for 4-benzyl-1,4-butanesultone, using allyl chloride instead of benzyl chloride. 4,4-Diallyl-1,4-butanesultone can be prepared by addition of a second allyl group.

Other catalytically active mercaptosulfonic acid oligomers can be
40 prepared from allyl vinylsulfonate ($\text{CH}=\text{CHSO}_2\text{OCH}_2\text{CH}=\text{CH}_2$), which was polymerized to form a corresponding sultone-containing polymer in accordance with E. Goethals, "Synthesis and Polymerization of Allyl Vinyl Sulfonate,"

Polymer Letters, Volume 4 (1966), Pages 691-693. The resulting polymer, containing sultone groups was treated with a reactive thiolate to open the sultone rings and produce mercaptoalkyl sulfonate polymers.

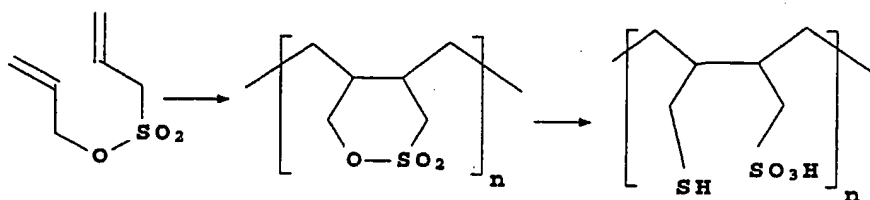
The conversions can be represented by the equation:

5



Similar catalytically-active solid oligomers can be prepared from oligomers of allyl allylsulfonate ($\text{CH}_2=\text{CHCH}_2\text{SO}_2\text{OCH}_2\text{CH}=\text{CH}_2$), which can be polymerized in accordance with E. Goethals et al., "Polymerization and Copolymerization of Allyl Sulfonate," J. Macromol. Sci. - Chem., Volume A5 (1971), Pages 63-72. The oligomers were converted to mercaptosulfonic acid functional materials by a corresponding ring opening reaction.

The conversion can be represented by the equation:

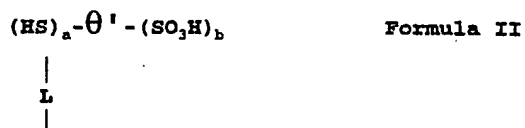


Heterocyclic residues advantageously include cyclic residues, containing N, O, or S. These will generally correspond to aromatic compounds, for example, residues from pyridine, thiophene, quinoline, phenanthridine, as well as the corresponding partially or fully hydrogenated compounds. Alkyleneheterocyclic residues otherwise correspond to aromatic residues of the same configuration, as do alkyl heterocyclic residues, as well as corresponding fully or partially hydrogenated compounds.

Preferred soluble mercaptosulfonic acids were compounds in which the mercaptan and sulfonic acid functions were separated by a chain of 2 to 10 atoms, whether the chain or linker arm was in an alkylene group or incorporated in an aromatic, cycloaliphatic or heterocyclic ring, whether or not the chain includes heteroelement, and whether or not the mercapto

and sulfonic acid functions were attached directly or indirectly to the ring structures. Preferred soluble catalysts for the practice of this invention were mercaptosulfonic acids in which a and b were independently from 1 to 4. More preferably, a and b were independently 1 or 2. Most preferred were mercaptosulfonic acids, containing mercapto and sulfonic acid functions in a 1:1 molar ratio, that was a and b were each 1, more particularly 3-mercaptopropanesulfonic acid and 4-mercaptobutanesulfonic acid.

When the mercaptosulfonic acid was insoluble, the heterogeneous catalyst comprises a catalytically-active species represented by Formula II:

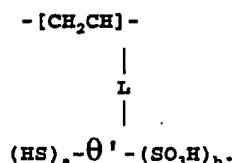


in which each of a and b was independently an integer from 1 to 20, θ' was an alkylene, cycloaliphatic, arylene, alkylenearylene, alkylene-cycloaliphatic, alkylenearyl, heterocyclic or alkyleneheterocyclic residue, L was an optional linking group and - was a bond, which catalytically-active species was attached by the bond - to an insoluble organic or inorganic support; or a catalytically-active species represented by Formula III:

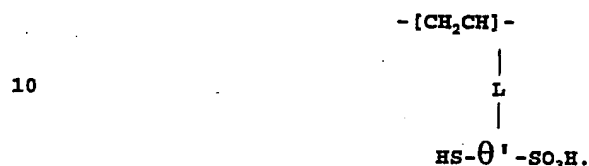


wherein θ'' was an alkylene, arylene, cycloaliphatic, alkylenearylene, alkylenecycloaliphatic, alkylenearyl, heterocyclic or alkyleneheterocyclic residue; a and b were independently selected from integers from 1 to 20; L' was an optional linking group and - was a bond.

Catalytically-active materials of Formula II were generally derived from polymers of ethylenic monomers, wherein the insoluble organic support was the main chain of a resulting polymer and -L- was a covalent bond or a linking group. This type of polymer will include unit structures represented by the general formula:



Preferably, the catalytically-active materials will include those having from 1 to 4 of each of mercapto and sulfonic acid groups per θ' . More preferably, the catalytically-active materials will include those having 1 or 2 of each of mercapto and sulfonic acid groups per θ' . Most preferably, the catalytically-active materials contain 1:1 ratios of mercapto and sulfonic acid functions and will correspond to the general formula:



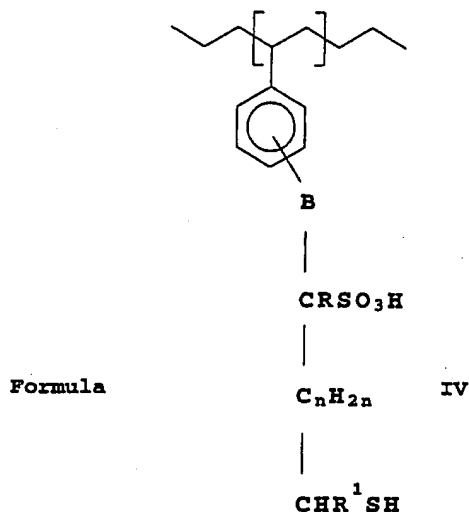
Exemplary polymers, made from ethylenically unsaturated monomers and which can be used as carriers for the catalytically-active species, include, but were not limited to:

<u>L</u>	<u>θ'</u>	<u>Monomer(s)</u>
-	phenyl	styrene
$-\text{CH}_2-$	phenyl	allylbenzene
$-\text{O}-$	phenyl	phenyl vinyl ether
$-\text{COO}-$	alkyl, aryl	acrylic esters
$-\text{OCO}-$	alkyl, aryl	vinyl esters
$-(\text{CH}_2)_r-$	alkenyl	α, ω -diolefins
$r = 4-20$		
$-\text{NH}-$	alkyl, aryl	vinylamines
$-\text{CONH}-$	alkyl, aryl	acrylamides
$-\text{NHCOO}-$	alkyl, aryl	vinylurethanes
-	alkylphenyl	vinyltoluene
-	phenyl	α -methylstyrene
$-\text{S}-$	phenyl	phenyl vinyl ether
$-\text{SO}_2-$	aryl	vinyl aryl sulfones
$-\text{SO}-$	aryl	vinyl aryl sulfoxides
$-\text{NSO}_2-$	aryl	aryl sulfonamide

The linking groups, -L-, accordingly can include alkylene, a covalent bond, oxycarbonyl, carbonyloxy, oxy, ureido, amido, amino, thio (sulfur), sulfono or sulfoxo. Preferred linking groups include a covalent

bond, methylene, sulfur or oxygen, more particularly a covalent bond joining a phenyl ring to a carbon backbone in polystyrene or polystyrene derivatives, each containing SH and SO₃H functions in single monomeric units of polystyrene.

One type of novel catalytically-active polystyrene resins, includes unit structures represented by Formula IV:



20 wherein B was a bridging group, R and R¹ were independently selected from H, alkyl or aryl, -C_nH_{2n}- was straight or branched chain alkylene and n was an integer from 0 to 20.

25 The bridging group B, can be selected from alkylene, generally as above. Alkyl and aryl are defined above.

30 Polystyrene resins of Formula IV can be made by the steps of (a) reacting a haloalkylstyrene polymer with a lithiated sultone, (b) treating a resulting sultone-functionalized polymer with a reactive thiolate and (c) acidifying the resulting intermediate to produce a polymer containing (mercaptosulfoalkyl)styrene units.

Haloalkylstyrene polymers include, but were not limited to poly(chloromethylstyrene), poly(bromomethylstyrene), poly(bromopropylstyrene), poly(bromopentyl)styrene.

35 Including homopolymers and copolymers, whether made by polymerization of haloalkylstyrene monomers or haloalkylation of polystyrene resins. Representative starting materials can be made by copolymerization of vinylbenzyl chloride or vinylbenzyl bromide with styrene. Either starting

material can be crosslinked with divinylbenzene or similar crosslinking monomers. The polymers can contain other monomers, for example, styrene, α -methylstyrene, acrylonitrile, butadiene, maleic anhydride, ethylene or propylene.

5 The haloalkylated polymers will advantageously contain from 0.5 meq/g to 10 meq/g of halomethyl groups. Halomethylated or haloalkylated polymers normally comprise mixtures of polymers, substituted in the ortho, meta- and para-positions.

10 Poly(chloromethylstyrene), containing 2 to 5 meq/g of chlorine, was a preferred starting material.

 The reaction sequence described above can be performed utilizing a variety of chloromethylated or bromomethylated styrene polymers or copolymers. In particular, crosslinked halomethylated styrene/divinylbenzene copolymers in various forms, for example,
15 microporous or macroporous beads, powders, can be functionalized to provide the corresponding mercaptosulfonic acid polymers.

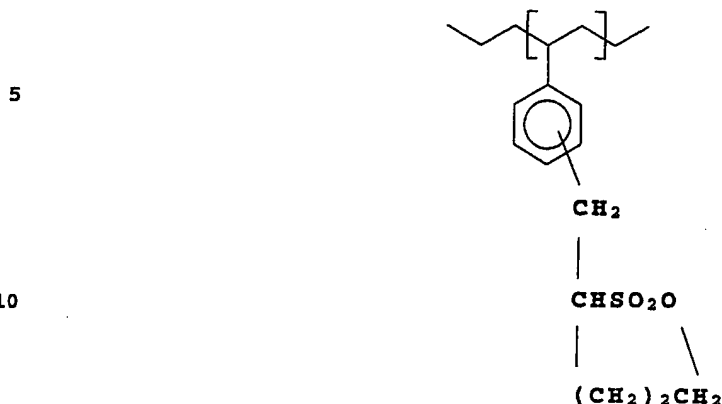
 In the case of all the polymer-based catalysts utilization of the functionalized styrene or other polymers in bead form may advantageously simplify workup procedures during preparation and provide for more facile
20 implementation in catalyst applications. Beads were suitably of any size through which effective flow and contact was achieved. Physical forms including powders, beads, extruded shapes, macroporous and microporous configuration were; however, suitably used in the practice of the invention. In general smaller size provides more surface area for
25 contact, but larger size permits greater flow through a bed. Optimizing these factors was within the skill of the art.

 Reactive thiolates advantageously include, but were not limited to, sodium thioacetate, potassium thioacetate, ammonium thioacetate and lithium thioacetate and the corresponding hydrosulfides. Of these,
30 lithium, sodium or potassium thioacetate was preferred.

 When conversion to a mercapto function was done through a thiourea intermediate, the thioureas were advantageously selected from thiourea, N-methylthiourea, N-ethylthiourea, N-phenylthiourea. In another alternative procedure, sodium thiosulfate can be used.

35 A preferred species of catalytically-active polystyrene resin was made by reacting poly(chloromethyl)styrene with lithiated 1,4-

butanesultone to produce an intermediate sultone, represented by the structural unit formula:



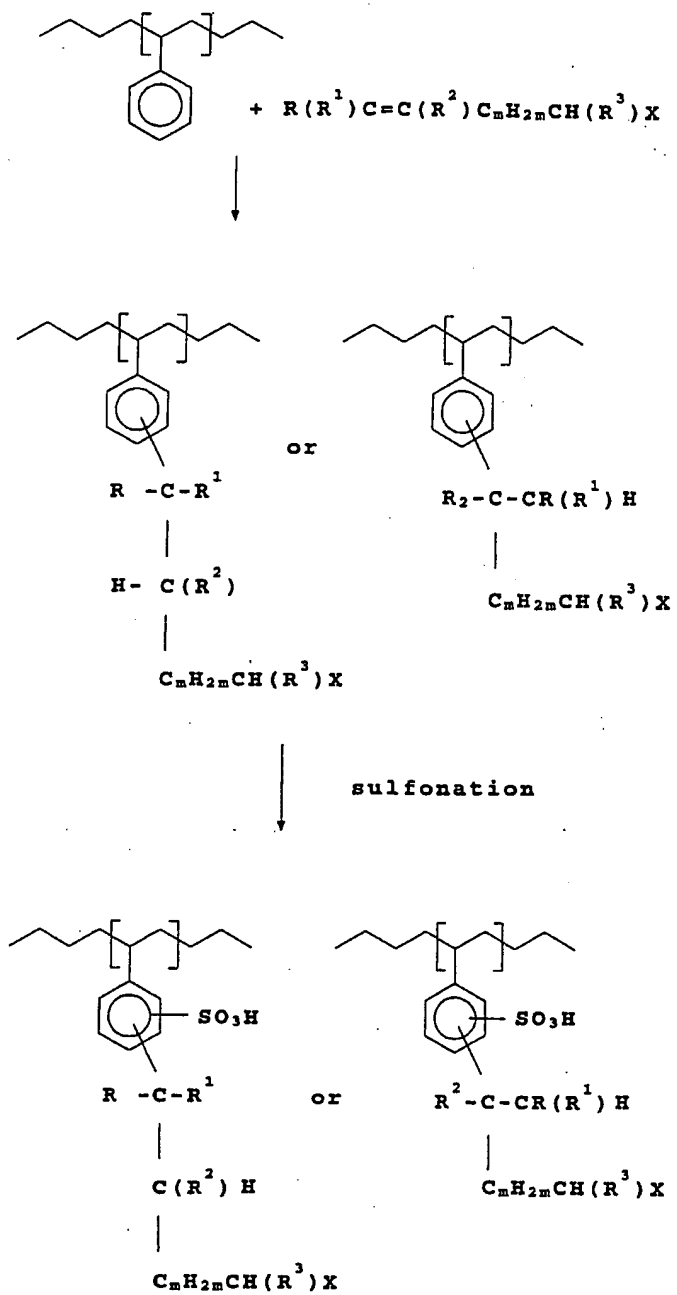
15 The resulting polymer contained (ϵ -mercapto- β --sulfopentyl)styrene units, that was, n in Formula IV was 2 and B was $-\text{CH}_2-$.

Most preferably, this type of resin was made from a slightly crosslinked polystyrene; the resulting catalytically active material was designated as PMBSA-MER.

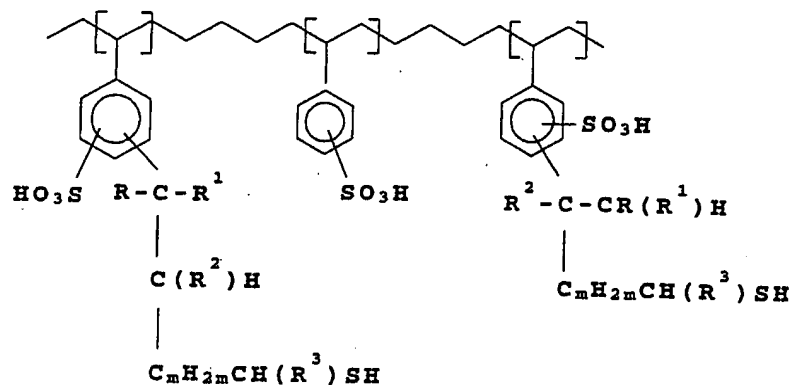
20 Another type of catalytically-active polystyrene resins can be prepared by the steps of:

- (a) alkylating a polystyrene with an alkenyl halide of the formula $\text{RC}(\text{R}^1)=\text{C}(\text{R}^2)\text{C}_m\text{H}_{2m}\text{CH}(\text{R}^3)\text{X}$, wherein each of R , R^1 , R^2 and R^3 was H, alkyl or aryl; m was 0 to 20 and X was F, Cl, Br or I to produce a haloalkyl polystyrene;
- 25 (b) sulfonating the resulting haloalkylpolystyrene to produce an intermediate having sulfo-functional groups;
- (c) optionally converting the sulfo-functional groups to a sodium or potassium sulfonate function;
- (d) thiolating the thus-produced sulfostyrene intermediate by
30 reacting the halo function with a reactive thiolate to produce a corresponding mercapto function or precursor thereof, and
- (e) optionally hydrolyzing the thus-thiolated intermediate with an acid or base when the thiolated group so requires; and
- (f) optionally acidifying (if so required) to produce the sulfonic
35 acid function.

This process can be represented broadly by the reaction sequence:

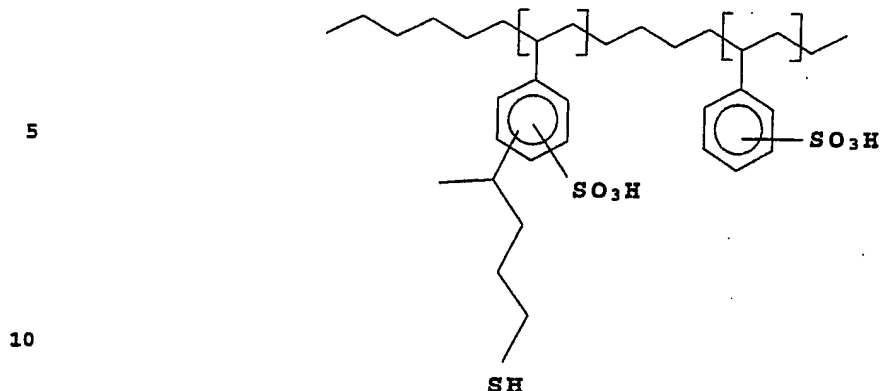


to produce intermediate haloalkyl sulfonated styrene polymers, of which halo functions were converted to mercapto-functions to produce the following types of products of Formula V:

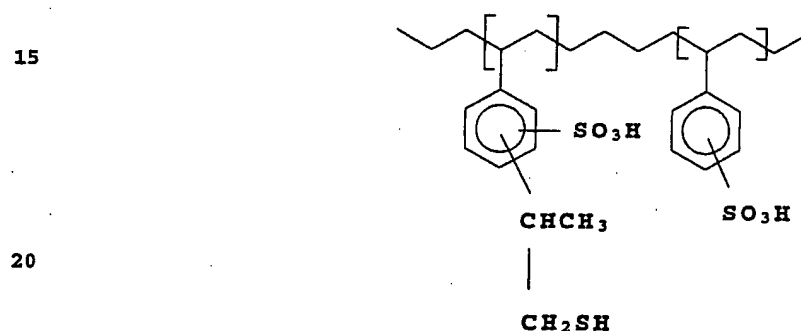


5 Alkenyl halides optionally contain aryl and alkyl substituents, as defined above. Representative alkenyl halides, useful for preparing the catalytically-active polymers, include, but were not limited to, allyl chloride, allyl bromide, allyl iodide, methallyl chloride, methallyl bromide, crotyl chloride, crotyl bromide, 4-bromo-1-butene, 5-bromo-1-butene, 6-bromo-1-hexene or higher chloro or bromoalkenes. Preferably, 10 the alkenyl halides were allylic halides, represented by the formula $\text{RC}(\text{R}^1)=\text{C}(\text{R}^2)\text{CH}(\text{R}^3)\text{X}$. Most preferably, the alkenyl halide was 5-bromo-1-pentene, 11-bromo-1-undecene or allyl bromide.

15 A particularly preferred product thus made can be characterized by the formula, in the case of a product from 5-bromo-1-pentene:



or, when the halide was allyl bromide or allyl chloride, by the formula:



Reactive thiolates were as defined above. Most preferably, the reactive thiolate was an alkali metal thioacetate or hydrosulfide.

By varying the choice of starting bromoalkene (or other haloalkene) used in the alkylation step of the process, the basic procedure described above can also be used to prepare a variety of catalysts with varying chain lengths between the mercaptan and sulfonic acid moieties. A number of catalysts with different amounts of mercaptosulfonic acid sites, depending upon the degree of functionalization in the alkylation and sulfonation steps in the process, and structural relationships between the mercaptan and sulfonic acid sites, depending upon the choice of bromo- or chloroalkylating agent, can accordingly be made.

Preferred catalytically-active species of Formula V were those derived from polystyrenes, treated with 5-bromo-1-pentene, 11-bromo-1-undecene or an allylic halide of the formula $RCH=CH_2CH_2X$, wherein R was H or alkyl of 1 to 5 carbon atoms.

In another aspect, this invention relates to novel (mercaptoalkyl) (sulfo)phenylalkyl sulfonated polystyrene catalysts, made by a process comprising the steps of:

(a) alkylating a haloalkylated polystyrene with a haloalkylarylene
5 compound to produce an intermediate haloalkylpolystyrene having
(haloalkyl)phenylalkyl styrene units;

(b) sulfonating the thus-produced haloalkylpolystyrene intermediate to produce an intermediate having sulfo-functional groups;

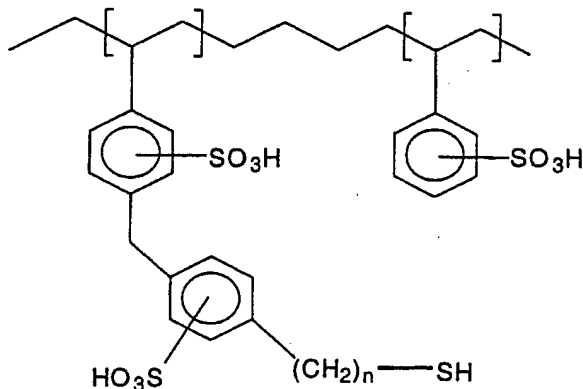
(c) optionally converting the sulfo functional groups to
10 corresponding alkali metal salts;

(d) thiolating the thus-produced sulfostyrene intermediate by reacting the halo function with a reactive thiolate to produce a corresponding mercapto function or precursor thereof and

(e) optionally hydrolyzing the thus-thiolated intermediate with an
15 acid or base when the thiolated group so requires; and

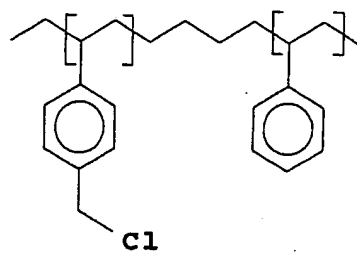
(f) optionally acidifying (if so required) to produce the sulfonic acid function.

This process produces polymers having repeating units of the formula:



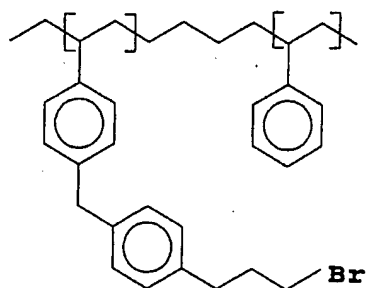
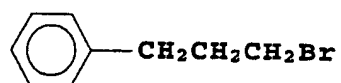
wherein n was preferably an integer from 0 to 10, more preferably 2 or 3.

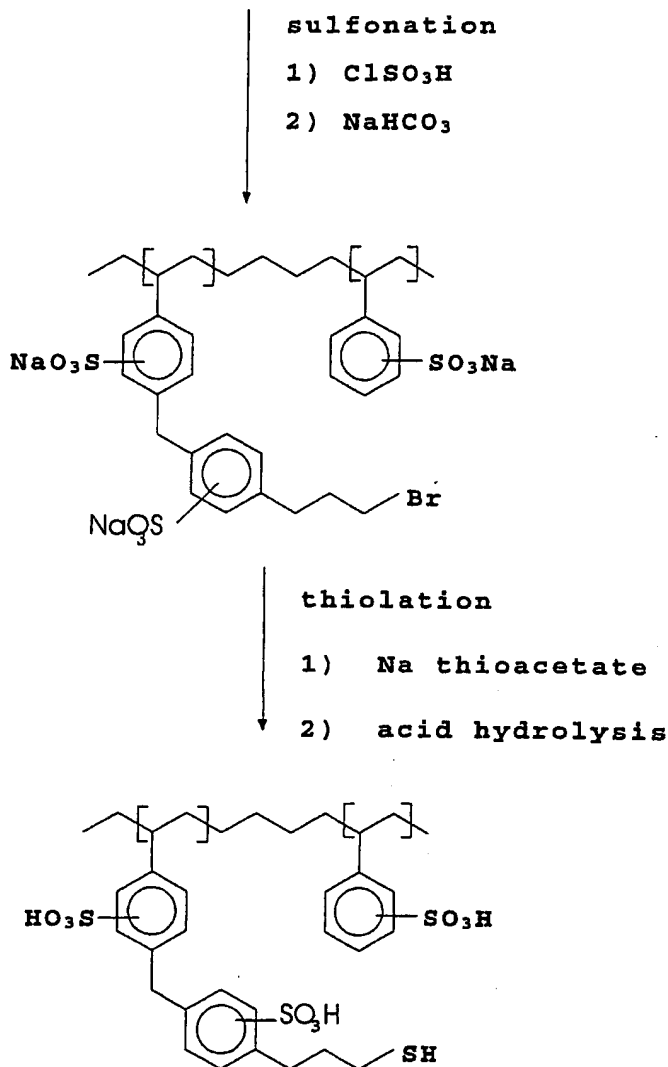
A representative member of this series of polymers, designated as DPMSA-XE3C was made from chloromethylstyrene polymer and 3-bromopropylbenzene, in accordance with the following reaction sequence:



alkylation

Lewis acid





The haloalkyl polystyrene starting materials can advantageously be selected from chloromethylated polystyrenes, bromomethylated polystyrenes, chloroethylated polystyrenes, iodoethylated polystyrenes, generally as above, preferably the halomethylated polystyrenes. Those skilled in the art recognize that selectivity decreases with haloalkyl groups on aryl rings which groups have similar selectivity.

The haloalkylarylene compound can conveniently be selected from chlorobenzene, (chloromethyl)benzene, (chloroethyl)benzene, (chloropropyl)benzene, (chlorobutyl)benzene, as well as the corresponding fluoro, bromo and iodo analogues. Representative examples include (2-

chloroethyl)benzene, (2-bromoethyl)benzene, (2-iodoethyl)benzene, 1-chloro-3-phenylpropane, 1-bromo-3-phenylpropane, and 1-iodo-3-phenylpropane. The bromo compounds were preferred.

The alkylation was conveniently carried out in the presence of a
5 Friedel-Crafts catalyst, of which aluminum trichloride, aluminum bromide, boron trifluoride, hydrogen fluoride, phosphoric acid, zinc chloride, titanium chloride, ethylaluminum dichloride and stannic chloride were representative. A preferred catalyst was aluminum chloride in nitromethane or nitrobenzene, as disclosed by A. Warshawsky et al.,
10 "Functionalization of Polystyrene. I. Alkylation with Substituted Benzyl Halide and Benzyl Alcohol Compounds", J. Org. Chem., Volume 43 (1978), Pages 3151-3157.

Conveniently, after alkylation, unreacted haloalkylbenzene, solvent and catalyst in the admixture were removed from the alkylated polystyrene
15 by means within the art such as filtration. Advantageously, the admixture was recycled for reaction with additional haloalkyl polystyrene. The alkylated polystyrene was optionally washed with a solvent such as dichloromethane and optionally dried.

The resulting alkylated polystyrene was sulfonated using
20 chlorosulfonic acid, oleum or other known sulfonating agents. Prior to conversion of the halo moiety to the mercapto moiety, it was convenient to convert the sulfo moieties to corresponding alkali metal salts. Chlorosulfonic acid, sulfuric acid or sulfur trioxide was conveniently used in an amount sufficient to achieve a predetermined or desirable
25 degree of sulfonation, advantageously to avoid unnecessary workup, in an amount not in large excess of the sufficient amount which varies with each resin but was determined without undue experimentation. The advantages of lower reaction temperatures were greater with chlorosulfonic acid.

The thiolating reagents were conveniently selected from those
30 disclosed above. Sodium thioacetate was preferred. Excess sodium hydrosulfide was optionally used for thiolation. Hydrolysis was then unnecessary since a thio group rather than a thioacetate was formed. The intermediate thiolated compound was, if necessary, acidified with a strong acid to convert sulfonate salt moieties to corresponding sulfonic acid
35 moieties. Advantageously, a mineral acid was used, as above.

In an alternate embodiment, the process comprises:

(a) alkylating a polystyrene resin with a halomethyl haloalkylarylene compound to produce an intermediate having (haloalkyl)phenylalkyl styrene units;

(b) sulfonating the thus-produced intermediate to produce an intermediate having sulfo-functional groups;

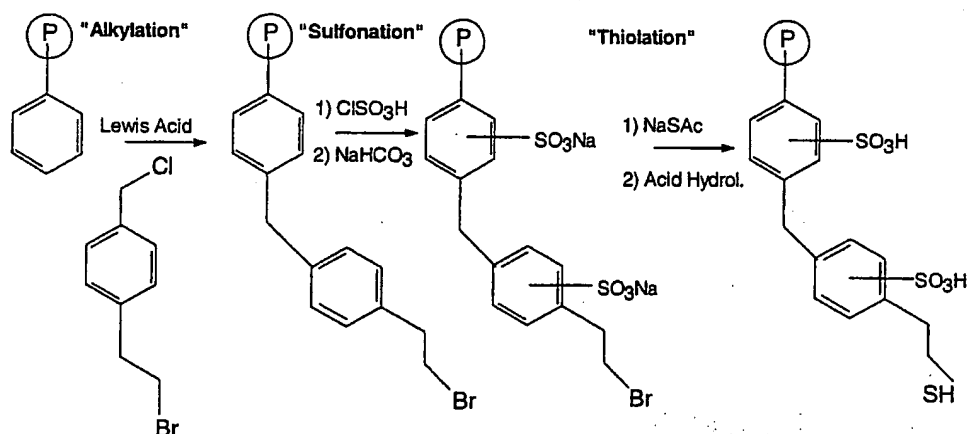
(c) optionally converting the sulfo functions to corresponding alkali metal salts;

(d) thiolating the thus-produced sulfostyrene intermediate by reacting the halo function with a reactive thiolate to produce a corresponding mercapto function or precursor thereof and

(e) optionally hydrolyzing the thus-thiolated intermediate with an acid or base when the thiolated group so required; and

(f) optionally acidifying (if so required) to produce the sulfonic acid function.

Illustrative of this reaction was the following sequence:



The alkylating step was performed as in the preceding process optionally in a solvent such as chloroform, 1,2-dichloroethane, dichloromethane, 1,2-dichloropropane, preferably a solvent which swells polystyrene (for example, styrene/divinylbenzene copolymer beads). The alkylating agent was any halomethyl haloalkylarylene preferably wherein the alkyl group has from 0 to 10 carbon atoms. The arylen group preferably has from 6 to 14 carbon atoms.

It was within the skill of the art to select halomethyl haloalkylarylenes in which the haloalkyl and halomethyl groups have activities sufficiently different to achieve the desired result.

Representative halomethyl haloalkylarylene compounds include
5 (2-bromoethyl)benzylchloride and (3-bromopropyl)benzylchloride.
Chloromethyl haloalkylarylenes were conveniently prepared by means within the skill of the art such as described by Selva et al., *Synthesis*, 1991, 1003-1004, wherein haloalkylarylenes were reacted with formaldehyde in acid (for example, sulfuric or hydrochloric) in the presence of a
10 quaternary ammonium phase transfer catalyst. Chloromethylation can also be performed using zinc chloride and paraformaldehyde in accordance with the method described by Daren in U.S. Patent No. 4,967,026.
Alternatively, chloromethyl ethers were used to chloromethylate a haloalkyl aryene by methods similar to that taught by Raley in U.S.
15 Patent No. 3,311,602, by Shinka, et al., *J. Poly. Sci. Polym. Lett. Ed.* 14(1), 1-3 (1976), and by Shigeo, et al., *Chem. Abstr.* 72:32290 (1970), or by other means within the skill of the art.

In another aspect, hydrohalogenating agents, such as, HBr were added to alkenyl arylenes, such as, styrene under radical forming conditions
20 such as taught by Martan in U.S. Patent No. 4,228,106 or Plesmid in U.S. Patent No. 3,321,536. In an extension of these works, vinylbenzyl chloride was hydrobrominated by this method.

The sulfonation and thiolation steps were as described for the previous process.

25 In addition to the methods disclosed above, a variety of other methods were also available for preparing the haloalkyl-functionalized polystyrene resins which were precursors to the mercaptosulfonic acid polymer catalysts. Representative approaches for preparing the haloalkylated polystyrene resins include (but were not limited to) those
30 described or discussed by: a) P. C. Reeves and M. S. Chiles, "Phase Transfer Catalysts Anchored to Polystyrene," *Tetrahedron Letters* (1979), Pages 3367-3370; b) M. Tomoi, et. al., "Novel Synthesis of Spacer-Modified Polymer Supports and Activity of Phase-Transfer Catalysts Derived from the Polymer Supports," *J. Polymer. Sci. Polymer Chem. Ed.*, Volume 20
35 (1982), Pages 3015-3019; c) M. J. Farrall and J. M. J. Fréchet, "Bromination and Lithiation: Two Important Steps in the Functionalization of Polystyrene Resins", *J. Org. Chem.*, Volume 41 (1976), Pages 3877-3882;

- d) S. P. McManus and R. D. Olinger, "Reactions of Cyclic Halonium Ions and Alkylene Dihalides with Polystyryllithium. Preparation of Haloalkylated Polystyrene", *J. Org. Chem.*, Volume 45 (1980), Pages 2717-2719; e) M. Haratake, et. al. "Sorption of Phenols on Anion-Exchange Resins Having .omega.-Oxoalkyl or .omega.-Hydroxyalkyl Spacer," *Analytical Sciences*, Volume 4 (1988), Pages 591-594; f) M. Gauthier and A. Eisenberg, "Alkylated Styrene Ionomers with Variable Length Spacers. I. Synthesis," *J. Polymer Sci.: Part A: Polymer Chem.*, Volume 28 (1990), Pages 1549-1568; g) P. Tundo, "Easy and Economical Synthesis of Widely Porous Resins; Very Efficient Supports for Immobilized Phase-Transfer Catalysts," *Synthesis* (1978), Pages 315-316; h) Tachikawa, et al., "Process for the Production of Silanes", (U. S. Patent No. 4,725,420); i) G. Zheng, et al., "Synthesis of Bromoalkylated Crosslinked Polystyrene", *Xinan Shifan Daxue Xuebao, Ziran Kexueban*, Volume 2 (1986) Pages 68-70; j) M. L. Hallensleben, "Preparation of Poly(p-(.omega.-lithiumalkyl)styrenes) and Their Use as Polymer Metalating Agents", *Angew. Makromol. Chem.*, Volume 31 (1973), Pages 147-159; k) F. Döschner et al., "Synthesis of Sulfoalkylated Styrene-Divinylbenzene Copolymers", *Makromol. Chem., Rapid Commun.*, Volume 1 (1980), Pages 297-302.

It was to be understood that a haloalkylated polystyrene resin prepared in a manner such as that described in the above references could be further functionalized by the sulfonation and thiolation procedures previously described to provide a mercaptosulfonic acid polymer catalyst.

Other representative references on methods for polymer modification or for uses of functional polymers include Akelah et al., "Application of Functionalized Polymers in Organic Synthesis", *Chem. Rev.*, Volume 81 (1981), Pages 557-587; Fréchet et al., "Functionalization of Crosslinked Polystyrene Resins by Chemical Modification: A Review in "Chemistry and Properties of Crosslinked Polymers", S. Labana, ed., Academic Press, New York (1977), Pages 59-83; and Maréchal, "Chemical Modification of Synthetic Polymers", in "Comprehensive Polymer Science", Volume 6, Allen, ed., Pergamon Press, New York, Pages 1-47.

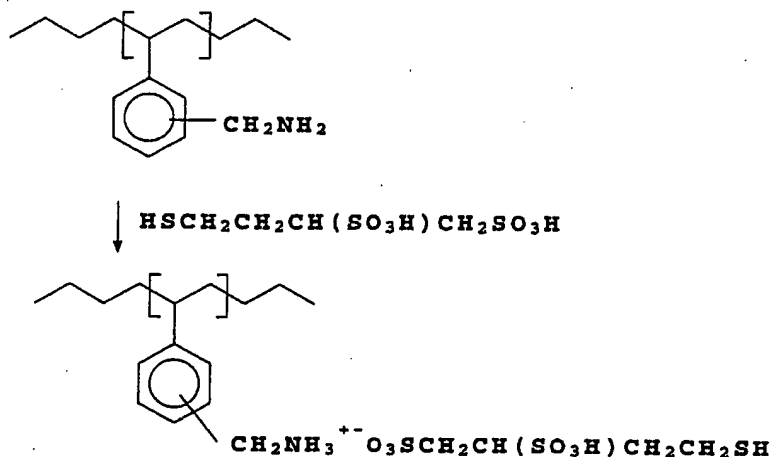
Catalysts derived from polystyrenes will advantageously contain from 0.2 to 5 meq of mercaptosulfonic acid functionality per g, most preferably from 2 to 4 meq/g.

It will be understood that polymers, containing large amounts of mercaptosulfonic acid functionality on a given carrier, pendant from a

hydrocarbon chain, can be prepared by grafting vinylsulfonic acid, propenesultone, to the pendant carrier function, and converting the grafted polymer to materials having mercapto/sulfonic acid functionality.

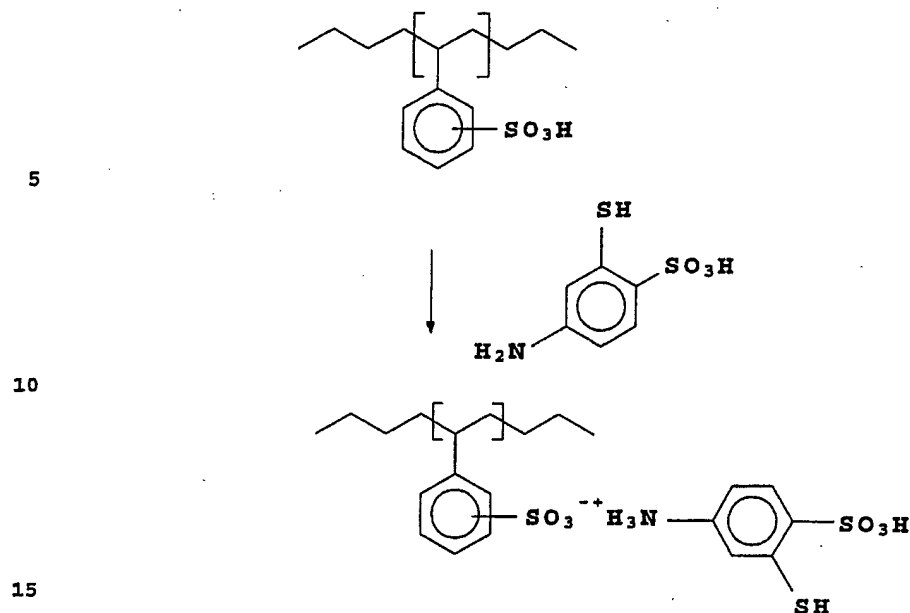
Catalytically-active polymers in which - was an ionic bond can advantageously be prepared from ion-exchange resins and reactive compounds, containing both mercapto and sulfonic acid functions.

For example, a strongly basic ion-exchange resin such as poly(vinylbenzyl amine) can be reacted with a compound such as 4-mercapto-1,2-butanedisulfonic acid to produce catalytically-active material as represented by the equation:



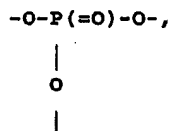
Representative strongly basic ion-exchange resins include DOWEX™ 1X2-400, from The Dow Chemical Company, Amberlyst™ A-21 from Rohm and Haas, DOWEX™ WGR-1, DOWEX™ WGR-2 and DOWEX™ MSA-1, from The Dow Chemical Company. The WGR resins were polypropyleneimines, conveniently obtained by condensation of epichlorohydrin with ammonia.

Catalytically-active materials can also advantageously be prepared from an acidic ion-exchange resin, for example sulfonated polystyrene by reaction with an aminomercaptosulfonic acid, for example, 2-mercapto-4-aminobenzene sulfonic acid, as represented by the equation:



Representative strongly acidic cation-exchange resins include DOWEX™ 50X2-400, Amberlyst™ A-21, from Rohm and Haas, and DOWEX™ MSC-1, from The Dow Chemical Company.

20 In addition to the use of polymers from ethylenically unsaturated monomers, including copolymers, as insoluble supports for the catalytically-active species, the catalytically-active species can be attached to an inorganic support, for example a mineral, such as silica, alumina, aluminosilicates or glass, through the linking group -L-. A
 25 representative case was that wherein the linking group was -OSiO- or



30

most preferably, -OSiO-.

Catalytically-active species of Formula III will conveniently be incorporated in the backbone of condensation polymers; for example, polyesters, polyamides, polycarbonates, polyurethanes, polysiloxanes,
 35 polyamines, polyethers, polyketones, polysulfones and polysulfoxides. The divalent linking group, -L'-, can be selected from such structures as polyoxy(alk-di-yl), polyoxy(ar-di-yl), dioxy(alkar-di-yl), polyoxy(aralk-

di-yl), polythio(alk-di-yl), polythio(aralk-di-yl), polythio(ar-di-yl), polythio(alkar-di-yl), polythio(aralk-di-yl), polyamido(alk-di-yl), polyamido(ar-di-yl), polyamido-(aralk-di-yl), polycarbonyloxy(alk-di-yl), polycarbonyloxy(ar-di-yl), polycarbonyloxy(alkar-di-yl), polycarbonyloxy-(aralk-di-yl), polycarbonyldioxy(alk-di-yl), polycarbonyldioxy(ar-di-yl), polycarbonyldioxy(alkar-di-yl), polycarbonyldioxy(aralk-di-yl), polyamino(alk-di-yl), polyamino(ar-di-yl), polyamino(alkar-di-yl), polyamino(aralk-di-yl), polycyclimido(ar-di-yl), polycyclimido(alkar-di-yl), polycyclimido(aralk-di-yl), polycarbonyl(alk-di-yl), polycarbonyl(ar-di-yl), polycarbonyl(alkar-di-yl), polycarbonyl(aralk-di-yl), polyimido(alk-di-yl), polyimido(ar-di-yl), polyimido(alkar-di-yl), polyimido(aralk-di-yl), polyureylene(alk-di-yl), polyureylene(ar-di-yl), polyureylene(aralk-di-yl), polyureylene alkar-di-yl, polycarboxamideoxy(alk-di-yl), polycarboxamideoxy(ar-di-yl), polycarboxamideoxy(alkar-di-yl), polycarboxamideoxy(alkar-di-yl), polycarboxamideoxy(aralk-di-yl), ar-di-yl, alkaryl-di-yl, aralkyl-di-yl and alkenoic-di-yl. Preferred divalent linking groups, -L'-, include di(carbonyloxy)hydrocarbylene, siloxy, dicarboxamidohydrocarbylene, di(oxycarbonyl)hydrocarbylene, dithiohydrocarbylene, and hydrocarbylene groups containing aromatic rings.

During batch processing, the mercaptosulfonic acid catalyst was suitably present in an amount sufficient to enable condensation of the phenol with the ketone/aldehyde in a reasonable time. Preferably, the amount of mercaptosulfonic acid ranges from 0.01 equivalents to 2.0 equivalents of catalyst per 1.00 equivalents of the ketone/aldehyde. More preferably, the amount of mercaptosulfonic acid catalyst was from 0.02 to 1.0 equivalent of mercaptosulfonic acid per equivalents of aldehyde/ketone. Most preferably, the reaction mixture will contain from 0.03 to 1.0 equivalent of mercaptosulfonic acid per equivalents of aldehyde or ketone under batch processing.

When ketone/aldehyde was added over the course of a reaction (for example, a continuous reaction) the previously stated preferred amounts refer to total catalyst and reactants added rather than catalyst present in a reaction mixture at a given moment. Those skilled in the art recognize that when a reactant was added incrementally or continuously, there was often a large excess of catalyst. The ratio of catalyst to ketone/aldehyde in the reaction mixture was advantageously greater than one, conveniently on the order of 20 equivalents to 1 equivalent.

Due to the high activity of the mercaptosulfonic acid catalysts, good reaction rates and high selectivity can be obtained at temperatures below the melting point of phenol. The phenol reactant can advantageously be kept in the liquid state by addition of solvents, for example, water, methylene chloride, diphenylmethane. Low temperature reactions were often particularly advantageous, because the product diphenolic compounds crystallize in the reaction mixture and because lower reaction temperatures favor higher selectivity toward 4,4-bisphenolic products.

The reaction temperature will accordingly advantageously be selected in the range from 0°C to 100°C, preferably from 15°C to 60°C. Temperature ranges can be chosen by routine experimentation, depending upon the ketone/aldehyde and phenol feeds.

When excess phenolic compound was used as solvent, the temperature for the condensation was advantageously selected so that the phenol was in the liquid state. In the case of high-melting phenols, for example, those melting above 180°C, the use of an inert solvent was preferred. Diphenylmethane has been found to be particularly useful for this purpose. Other useable inert solvents include, but were not limited to, the xylenes, mesitylene, the durenes, fluorobenzene, toluene, cyclohexane, chlorobenzene, halogenated aliphatic hydrocarbons and alkyl-naphthalenes having low melting points.

If a solvent/diluent was used, the amount used conveniently ranges from 5 mL to 1 L per mole of ketone or aldehyde. Preferably, from 200 mL to 400 mL were used per mole of ketone or aldehyde.

The addition of water, generally in an amount up to a maximum of 5 percent by weight of total feed, was considered highly desirable in processes for the preparation of bisphenol A, because water lowers the freezing point of phenol and addition of water permits the condensations to be run at lower temperatures. Most preferably, the amount of added water was from 1 percent by weight to 5 percent by weight of total feed.

The reaction can advantageously be carried out by stirring the ketone or aldehyde and mercaptosulfonic acid into molten phenol in such a way that the temperature in the reaction vessel will not rise above 150°C.

The molar ratio of phenolic reactant to ketone or aldehyde was advantageously selected so that at least two moles of phenol will condense with the ketone to produce a corresponding bisphenol or higher condensate. Therefore, molar ratios of 2:1 or higher will advantageously be selected.

It was preferred to carry out the reactions using larger excesses of phenolic reactant, up to as much as 50 moles of phenol per mole of ketone or aldehyde. It will be understood that the excess phenol acts as a solvent or diluent, as well as a reactant.

5 Lower ratios of phenol to ketone/aldehyde were generally accompanied by an increase in the amount of by-products formed. In the preparation of polyphenols, it has been found that molar ratios from 2:1 to 30:1 of phenol to aldehyde/ketone were preferred. More preferably, the reaction mixtures will contain from 4:1 to 25:1 molar ratios of phenol to
10 aldehyde/ketone. Most preferably, the molar ratio was from 6:1 to 25:1.

Since the condensation reaction was exothermic, the reactants, instead of being mixed together all at once, were optionally progressively mixed together at a speed depending upon the intensity of the cooling employed to maintain the temperature of the reaction medium within the
15 optimum limits. After the mixing of the reactants, they were preferably left in contact for some time in order to complete the condensation. The duration of the introduction of the reactants during a batch process conveniently varies from 15 minutes to 1 hour.

In batch processes, the reactants and the catalyst were preferably
20 thoroughly stirred mechanically to assure better mixing, and hence an improved space-time yield.

When the process of this invention was conducted batch wise, the reaction time was advantageously in the range of 0.1 to 20 hours depending on the reaction conditions including the amount of the catalyst used, the
25 reaction temperature, and specific reactants, solvents and products.

The process of this invention can also be run in a continuous mode, more preferably by use of a series of continuous stirred tank reactors, the use of which approximates plug flow reaction conditions. It was preferred to carry out the process of this invention under continuous
30 reaction conditions.

The pressure in the reaction zone was not critical, but preferably ranges from 0.001 to 10 bar (0.1 to 1000 kPa), and more particularly from 0.5 to 3 bar (50 to 300 kPa). In many cases, it will be preferred to carry out the reactions under ambient pressure, that was, 1 bar (100 kPa).

35 During the reaction, one mole of water was evolved for each mole of ketone/aldehyde undergoing the condensation with phenol. It has been found that adding water to the reaction mixtures can be advantageous for

decreasing the melting point of phenol. The water evolved during the reactions need not be removed by distillation/entrainment with an inert solvent in order to attain high reaction rates. In some cases, however, it will be preferred to entrain and remove water from the reaction mixture, in order to increase reaction rates.

It has been found that the soluble mercaptosulfonic acid catalysts can advantageously be removed from the crude product by extraction with water. The aqueous extracts can be concentrated and recovered mercaptosulfonic acid catalyst can be optionally recycled to subsequent runs. When the phenolic starting material was phenol, a solution of the mercaptosulfonic acid in phenol was conveniently recovered and was optionally recycled without further purification.

The acid concentration can be reduced below the limits of detection, and probably below 1 ppm by weight of acid, by repeated extractions with water. The facile removal of catalyst from the reaction mixtures was a significant advantage over the prior art, using mixtures of condensing agents. It was within the practice of this invention to remove the mercaptosulfonic acid by continuous countercurrent extraction.

The time for phase separation during extraction of the acid catalyst was on the order of 10 to 15 minutes under batch conditions, without a drag layer. Stirring speed during the extraction in a mixer/settler was adjusted so as to avoid emulsion formation.

The soluble mercaptosulfonic acid catalysts can also be removed from reaction mixtures by extraction with a solution of an alkali metal hydroxide, carbonate or bicarbonate.

In addition, the soluble mercaptosulfonic acid catalysts can be removed from reaction mixtures by passing the reaction mixture through a column of anion-exchange resin or amine resin, such as DOWEX™ WGR, from The Dow Chemical Company.

A water purge from the process will contain phenol plus catalyst. This purge was advantageously treated to remove phenol by extraction with methyl isobutyl ketone before being sent to a bio-pond for disposal.

For isolation of BHPF from reaction mixtures, made using a soluble catalyst, a phenol/water mixture was preferably distilled from the water-washed mixture until the weight ratio of phenol:BHPF was below 1.5:1. Most preferably, phenol was removed until the phenol:BHPF weight ratio was from 1.5:1 to 0.5:1. It has been found particularly advantageous to

dissolve the resulting material in hot methylene chloride and cool the resulting solution to obtain crystalline BHPF.

Very highly purified BHPF accordingly can be obtained by a process wherein a resulting crude product was washed with water to remove $(HS)_a-O-(SO_3H)_b$; the resulting acid-free mixture was distilled to remove phenol and water until the phenol:9,9-bis-(4-hydroxyphenyl)fluorene weight ratio was less than 1.5; the resulting mixture was taken up in hot methylene chloride and the resulting solution was cooled to produce crystalline 9,9-bis-(4-hydroxyphenyl)fluorene. BHPF purified in this way can be used to make ultrahigh quality polycarbonate resins.

Excess phenol can also be removed by boiling the reaction mixture repeatedly with water, optionally with the use of a water-miscible organic solvent such as methanol. The aqueous solution was separated each time and the product, then practically pure, was dried. Another effective method of removing excess phenol was by steam distillation.

The reaction product solution was optionally then concentrated by evaporation and repeatedly extracted with boiling water for the removal of excess phenol. The product so obtained was optionally then recrystallized for further purification.

BHPF can be isolated from the reaction mixtures in several additional ways. The method selected will depend on the degree of purification desired, as well as the composition of the reaction mixture, and the desired production rate.

When extensive purification was undesirable or inappropriate, the mixture, after being treated to remove catalyst, can be treated with a volume of hot water sufficient to dilute the mixture and bring precipitation of BHPF. Alternatively, the reaction mixture can be added to hot water and the phenol removed in the form of a water/phenol azeotrope until the phenol content was lowered sufficiently to permit precipitation of BHPF from the mixture. The BHPF solids can be collected and dried before use or can be used in the form of a slurry.

When more extensive purification of BHPF was desired, the solids can be purified by precipitation from a solvent, for example, diphenylmethane or methylene chloride.

Another method for isolating BHPF comprises adding to the reaction mixture, at the end of the reaction, a solvent, boiling at a higher temperature than phenol, and removing phenol from the phenol/BHPF/solvent

mixture until BHPF crystallizes or precipitates from the mixture. This method can be carried out by adding diphenylmethane or triisopropylbenzene to a reaction mixture, from which catalyst has been extracted or removed, prior to distilling the mixture. Alternatively, the solvents can be added to the initial reaction mixture so that the reactions were run in the presence of the solvent. The reaction mixture was worked up, by extraction, to remove catalyst and then by distillation to remove solvent and phenol, until BHPF crystallization occurs.

BHPF can also be isolated by adding to a reaction mixture a solvent, which boils at a higher temperature than phenol and dissolves sufficient BHPF, in the absence of phenol, that removing phenol from the phenol/BHPF/solvent mixture provides a homogeneous solution, cooling of which causes crystallization of BHPF. Solvents meeting these requirements include diphenylmethane, diphenyl ether, dodecane, naphthalene, Isopar™ (hydrocarbon mixture commercially available from Exxon Corporation) and triisopropylbenzene.

Further purification can also be accomplished, after removing catalyst from the reaction mixture, by distilling to remove phenol to a level at which BHPF crystallizes from the phenol/BHPF mixture. The BHPF solids obtained can be isolated by conventional means and then further treated, for example, by washing with water to remove phenol.

An alternative method for obtaining high purity BHPF comprises removing catalyst from the reaction mixture, distilling phenol from the reaction mixture to a phenol/BHPF level such that dilution of the distillation residue with a solvent induces crystallization of the BHPF from the phenol/BHPF/solvent mixture. For example, phenol can be removed by distillation until the distillation residue contained 50 percent by weight of phenol and 50 percent by weight of BHPF. Methylene chloride, triisopropylbenzene or toluene can be added to the residue and the resulting solution can be cooled to bring about crystallization of highly purified BHPF.

Another procedure for isolating pure BHPF solid from the reaction comprises removing the mercaptosulfonic acid catalyst, distilling phenol from the resulting mixture, to produce a still residue, to which addition of a solvent induces crystallization of BHPF. For example, a still residue containing 80 percent by weight of phenol and 20 percent by weight

of BHPF can be diluted with a solvent, for example dichloromethane or toluene, to induce crystallization of BHPF.

In addition, BHPF can be isolated from a reaction mixture, by removing the mercaptosulfonic acid catalyst, adding to the resulting
5 reaction mixture a solvent, which forms an azeotrope with phenol and in which BHPF was soluble in the absence of phenol, and removing phenol from the mixture by azeotropic distillation. Cyclohexanol was exemplary of a solvent, which will form an azeotrope with phenol and from which BHPF will precipitate upon cooling the still residue from the azeotropic
10 distillation.

Similarly, phenol can be removed from the reaction mixtures by addition of a solvent, which forms an azeotrope with phenol. After removing phenol by azeotropic distillation, the still residue was cooled and BHPF crystallizes out from the cooled mixture.

15 In any of the purification processes which result in a crystalline product, the catalyst was optionally not removed before crystallization of product but rather either tolerated in the product or removed from the crystals, for instance by washing or other means within the skill of the art, after crystallization.

20 In some cases, the condensation of phenol with ketones or aldehydes can be run in a solvent, for example, methylene chloride, from which the product will precipitate during the course of the reaction, as was described in more detail for the preparation of bisphenol A.

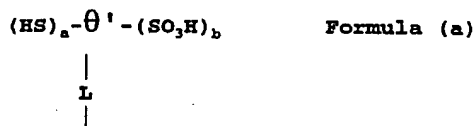
A representative solvent used for crystallization of BHPF, methylene
25 chloride, can be recovered from the mother liquors by batch distillation and recycled back to the process. The still bottoms contain BHPF and methylene chloride and can be cooled to recover additional BHPF. BHPF crystals thus formed were conveniently recovered using a basket centrifuge or pressure filter and can be recycled back to a main crystallizer. Crude
30 mother liquor can also be recycled back to the phenol evaporation section.

When methylene chloride was used as solvent for crystallizing BHPF, a common vent header for collecting all vents from storage tanks and safety relief systems was recommended. The vent header system advantageously includes a flow measurement device in the inlet to a carbon
35 adsorption unit and a VOC analyzer for the exit gas. The exit gas should contain less than 100 ppm of methylene chloride. A complete effluent treating system will advantageously include means for removing organics

from process waters and means for removal of particulates from vent gas, for example, a water venturi flow meter to scrub particulates from the vent header.

A further advantage of the catalysts used in the practice of this invention was that the catalysts can be used to isomerize the crude product mixture, which typically contained (4-hydroxyphenyl)(2-hydroxyphenyl) compounds, the major bis-(4-hydroxyphenyl) compounds, and condensates, to produce more of the bis-(4-hydroxyphenyl) compounds.

Isomerization of a geminal bisphenol using the catalysts of the invention was useful when practiced with the process of the invention or separately, for example, after product formation using catalysts within the skill of the art. For instance, a mixture of p,p-bis(hydroxyphenyl)fluorene and o,p-bis(hydroxyphenyl)fluorene was contacted with a mercaptosulfonic acid catalyst, preferably of the formula (HS)_a-Φ-(SO₃H)_b or of formula (a)



in which θ' was an alkylene, cycloaliphatic, arylene, alkylenearylene, alkylencycloaliphatic, alkylenearyl, heterocyclic or alkyleneheterocyclic residue; a and b were independently selected from integers from 1 to 20; L was an optional linking group and - was a bond, which catalytically-active species was attached by the bond - to an insoluble organic or inorganic support; and heated sufficiently to result in formation of the p,p (bis(4-hydroxyphenyl) product from at least a portion of the o,p (2-hydroxyphenyl, 4-hydroxyphenyl product. The catalyst was a compound (including polymer) of the formula (HS)_a-Φ-(SO₃H)_b or of formula (a), preferably those preferred for the reaction of an aldehyde or ketone with a phenol as described herein, with 3-mercaptopropanesulfonic acid most preferred. It was noted that such catalysts result in conveniently fast isomerization and less formation of additional by-products than do acids such as methane sulfonic acid. Temperatures, which will vary with the compound being isomerized, were suitably any temperature at which isomerization takes place, and were conveniently at least room temperature (30°C), preferably at least 40°C, more preferably at least 50°C. The temperature was preferably lower than that temperature at which an

undesirable amount of additional by-product or polymer would form, conveniently less than 100°C, more preferably less than 85°C, most preferably less than 75°C. Seventy degrees centigrade was a convenient and preferred temperature. It was found that increasing the temperature within the range speeds isomerization. Likewise, increasing the concentration of catalyst increases isomerization. Catalyst was preferably present in any amount sufficient to result in isomerization. Less was needed at higher temperatures to obtain a desirable rate of isomerization. Conveniently, the catalyst was present in the same amounts and preferred ranges as for preparation of a bisphenol by the process disclosed herein. The pressure was not critical, but was also conveniently within the preferred ranges for the process of preparing bisphenols by the process herein. Time for the isomerization was preferably that in which, under the conditions, results in isomerization of at least a portion, more preferably a predetermined or desired fraction of the o,p by-product being isomerized to the desired p,p product. More preferably the ratio of o,p to p,p product was less than 0.12, most preferably less than 0.1, even more preferably less than 0.075. The time to achieve this result varies with isomerization conditions but was conveniently less than a day, more preferably less than 12 hours, most preferably less than 8 hours, for conversion of half of the o,p product to p,p product.

The mercaptosulfonic acid catalysts of this invention were considerably less corrosive to stainless steel than the mixed catalysts used previously. Corrosion rates for stainless steel, below 0.00254 cm/year, have been measured. The reaction mixtures were believed to be substantially free of halide ions, wherein "substantially free" means less than 5000 ppm of chloride ions.

The process of this invention was advantageously carried out under conditions such that the concentration of chloride was below 5000 ppm, preferably below 1000 ppm, most preferably below 100 ppm.

It was believed that the low corrosion rate was related to the absence of mineral acids, such as hydrochloric acid or sulfuric acid, from the reaction mixtures. The occurrence of corrosion in reactions using mineral acids has been noted by Knebel et al., '594 and Faler '995, supra.

The insoluble catalysts of this invention can be filtered from the reaction mixtures, washed with a mixture of ketone/aldehyde and phenol,

and recycled to subsequent runs. Alternatively, the insoluble catalysts were used in fixed beds and the condensations of phenols with aldehyde/ketone was done in continuous upflow, crossflow or downflow fashion. When fixed-bed catalytic reactors were used, the catalytically-
5 active resins remain in the resin beds and need not be removed.

Further embodiments of this invention will be determined by the reactants used, the catalyst selected, the diluent, if any, and the reactor employed.

For example, when using a soluble catalyst for the condensation of
10 phenol with 9-fluorenone, without a diluent, other than excess phenol or in the presence of a diluent which does not cause precipitation of product, it will generally be preferred to use a high ratio of phenol to fluorenone to maximize selectivity to the desired bisphenol product.

A particularly preferred process was one wherein the molar ratio of
15 phenol:fluorenone was from 4:1 to 25:1; the reaction temperature was from 25°C to 50°C; the catalyst was mercaptopropanesulfonic acid or mercaptobutanesulfonic acid, used in an amount from 5 to 10 molar percent with respect to fluorenone; the process was carried out under ambient pressure or under vacuum to remove water of reaction and increase the
20 reaction rate; no cosolvent was used; the catalyst was removed from the product by extraction with water using a wash column or by batch extraction; the water extracts thus obtained were concentrated and recycled to the process; the product was isolated by removing excess phenol to a weight ratio from 1.5:1 to 0.5:1 of phenol:BHPF and the
25 product was precipitated with dichloromethane.

When an insoluble catalyst was used, a particularly preferred process was one wherein the molar ratio of phenol:fluorenone was from 4:1 to 25:1; the condensation was carried out at a temperature from 40°C to 60°C; no cosolvent was used; the catalyst was PMBSA; the condensation was
30 carried out in a continuous plug flow reactor; the reaction was carried out at ambient pressure or under reduced pressure to remove water of reaction and increase the reaction rate; the product was isolated by removing excess phenol to a weight ratio from 1.5:1 to 0.5:1 of phenol:BHPF and the product was precipitated with dichloromethane.

35 The process for making BHPF can also be carried out at molar ratios of phenol:fluorenone from 7:1 to 5:1 in the presence of 0.05 to 0.15 equivalent of MPSA or MBSA per mole of fluorenone, wherein methylene

chloride was added to the reaction mixture after conversion of at least 20 percent of fluorenone has occurred; heating the resulting mixture under reduced pressure to remove an azeotrope of methylene chloride and water; and cooling the mixture at the end of the condensation reaction to cause precipitation of BHPF.

The condensation of phenol with fluorenone can further be carried out using a feed containing from 5:1 to 3:1 molar ratio of phenol:fluorenone and from 0.05 to 0.15 equivalent of MPSA or MBSA per mole of fluorenone, diluted with from 10 percent by weight to 30 percent by weight of methylene chloride. Crystalline BHPF can be collected from the cooled reaction mixture.

In addition, BHPF can be prepared from a reaction mixture, containing from 18:1 to 12:1 molar ratios of phenol:fluorenone and 0.025 to 0.075 equivalent of MPSA or MBSA per mole of fluorenone at a temperature from 50°C to 80°C, wherein the mixture at the end of the reaction was diluted with 10 to 20 volumes of water to extract mercaptosulfonic acid catalyst, the thus-washed mixture was distilled to a phenol:BHPF weight ratio from 1.5:1 to 1:1 and cooled to bring crystallization of BHPF. The crystalline BHPF was removed by filtration and washed with methylene chloride and then with water.

A process in which the product was precipitated in the reaction mixture was preferred for the preparation of bisphenol A, more particularly a process wherein the phenol:acetone feed contained from 6:1 to 15:1 molar ratios of phenol:acetone; the condensation was carried out at a temperature from 25°C to 35°C; the reaction mixture contained up to 5 percent by weight of water to lower the freezing point of phenol; the catalyst was 3-mercaptopropanesulfonic or 4-mercaptobutanesulfonic acid in an amount from 0.05 to 0.50 equivalent per mole of acetone in the acetone:phenol feed; the reaction was carried out under ambient pressure; and the crystalline bisphenol A produced by the process was removed by filtration or centrifugation.

Further processing can include washing the bisphenol A with water to partially remove soluble catalyst, and removing additional soluble catalyst by treatment with an anion exchange resin. It was believed that a preferred reactor configuration for this process was a series of

continuous stirred tank reactors, so as to approximate plug flow reaction conditions.

Other process variations, include, but were not limited to:

- (a) preparation of bisphenol A in neat phenol, using a soluble catalyst, with precipitation of bisphenol A in the reaction mixture and
- (b) preparation of bisphenol A in phenol with a complex-forming cosolvent and soluble catalyst, with precipitation of bisphenol A in the reaction mixture.

More particularly, it was preferred to select a catalyst wherein at least 99 percent of the bisphenol A that crystallizes during the reaction was 4,4-bisphenol A. Such catalysts include soluble mercaptosulfonic acids in which a and b were each independently integers from 1 to 4. Preferred conditions include reaction temperatures from 0°C to 50°C, more preferably from 20°C to 40°C.

Representative complex-forming solvents for bisphenol A include diethyl ether, acetone, ethanol, propanol, dioxane, acetic acid, acetonitrile, methylene chloride or carbon tetrachloride. The complex-forming solvents complex preferentially with the 4,4-diphenolic isomer so that the resulting complex has solubility properties, differing from that of the uncomplexed 2,4-diphenolic compound and can be readily separated therefrom.

These processes can be run under varying pressure and temperature conditions, as well as reactant, cosolvent and catalyst concentrations, as can be determined by routine experimentation.

In one aspect, a most preferred process of this invention was that wherein the ketone was 9-fluorenone, the phenol was unsubstituted and the product was 9,9-bis-(4-hydroxyphenyl)fluorene; the molar ratio of phenol to fluorenone was from 8:1 to 25:1; the reaction mixture contained from 0.05 to 0.20 equivalent of mercaptosulfonic acid per mole of fluorene; the mercaptosulfonic acid compound was 3-mercaptopropanesulfonic acid or 4-mercaptobutanesulfonic acid and the process was carried out at a temperature from 45°C to 60°C.

An equally preferred process was that wherein the ketone was acetone, the phenol was unsubstituted and the product was 2,2-bis-(4-hydroxyphenyl)propane; the molar ratio of phenol to acetone was from 6:1 to 15:1; the reaction mixture contained from 0.10 to 0.50 equivalent of mercaptosulfonic acid per mole of acetone; the mercaptosulfonic acid

compound was 3-mercaptopropanesulfonic acid or 4-mercaptobutanesulfonic acid and the process was carried out at a temperature from 15°C to 60°C.

Without further elaboration, it was believed that one skilled in the art can, using the preceding description, utilize the present invention to the fullest extent. The following preferred specific embodiments were, therefore, to be construed as merely illustrative and not limitative of the remainder of the disclosure in any way whatsoever.

In the following examples, the temperatures were set forth uncorrected in degrees Celsius. Unless otherwise indicated, all parts and percentages were by weight.

Reactor Design 1: A 500-mL reactor prepared from PFA Teflon® (material from DuPont) was fitted with a thermocouple port, water condenser topped with nitrogen inlet, mechanical stirrer, drain port, and sampling port. Heating was provided with an infrared heat lamp and the temperature was controlled with an electronic thermometer/temperature controller.

Reactor Design 2: A capped 4-dram glass vial with a magnetic stirrer. Heating was regulated by placing the vial in a temperature-controlled aluminum block heater.

Reactor Design 3: A 100-mL jacketed glass reactor was fitted with a thermometer port, magnetic stirrer, nitrogen inlet, and sampling port. Heating was provided and the temperature was controlled by circulating glycol solution of the appropriate temperature through the jacketed flask using a Neslab Model RTE-220 circulating bath.

Reactor Design 4: A 1.5 L, 2 L, or 3 L jacketed glass reactor fitted with a thermometer/sampling port, nitrogen inlet, and mechanical stirrer. Heating was provided and the temperature was controlled by circulating glycol solution of the appropriate temperature, through the jacketed flask using a Neslab Model RTE-220 circulating bath.

Analytical Method 1: A Varian HPLC System (Model 9010 solvent delivery system, Model 9095 Autosampler, Model 9065 Polychrom diode array detector) interfaced with a Varian Star workstation was used for analysis. Area percent analysis was reported at 282 nm. Percent conversion was determined by an external standard method using calibrated concentration curves for each major component. Analytical HPLC samples were prepared by careful quantitative dilution of reaction samples (range: 400-500 times dilution). Column: Waters Nova-Pak C-18 (60 Angstrom, 4 micron, 3.9 X

150 mm). Chromatography conditions: flow rate 1.0 mL/min, solvent gradient (solvent A = water, solvent B = acetonitrile) 0 minutes: 65 percent A/35 percent B, 9 minutes: 60 percent A/40 percent B, 18 minutes: 55 percent A/45 percent B, 24 minutes: 45 percent A/ 55 percent B, 48 minutes: 5 percent A/ 95 percent B, 52 minutes: method end (10 minutes equilibration before and after runs).

Analytical Method 2: A Hewlett-Packard HPLC system (Model 1084B solvent delivery system, Model 79850B LC terminal) was used for analysis. Area percent analysis was reported at 254 nm. Percent conversion was determined by an external standard method using calibrated concentration curves for each major component. Analytical HPLC samples were prepared by careful quantitative dilution of reaction samples (range: 400-500 times dilution). Column: Waters Nova-Pak C-18 (60 Angstrom, 4 micron, 3.9 X 150 mm). Chromatography conditions: flow rate 1.0 mL/min, solvent gradient (solvent A = water, solvent B = acetonitrile) 0 minutes: 65 percent A/35 percent B, 9 minutes: 60 percent A/40 percent B, 18 minutes: 55 percent, A/45 percent B, 24 minutes: 45 percent A/ 55 percent B, 36 minutes: 25 percent A/ 75 percent B, 38 minutes: 65 percent, A/35 percent B, 38 minutes: method end. NOTE: This method gives a smaller response (approximately one-half the area) for the 2,4-BHPF and the two:three adduct BHPF peaks relative to the 4,4- BHPF peak than either methods 1 or 3 using the diode array detector.

Analytical Method 3: A Varian HPLC system (Model 9010 solvent delivery system, Model 9095 Autosampler, Model 9065 Polychrom diode array detector) interfaced with a Varian Star workstation was used for analysis. Area percent analysis was reported at 282 nm. Percent conversion was determined by an internal standard method using a solution of 0.0508 weight percent acetophenone in 60/40 (weight/weight percent) methanol/water for preparing the samples. Analytical HPLC samples were prepared by careful quantitative dilution of reaction samples. Column: Waters Nova-Pak C-18 (60 Angstrom, 4 micron, 3.9 X 150 mm). Chromatography conditions: flow rate 1.0 mL/min, solvent gradient (solvent A = water, solvent B = methanol) 0 minutes: 55 percent A/45 percent B, 20 minutes: 15 percent A/85 percent B, 25 minutes: 10 percent A/90 percent B, 30 minutes: 55 percent A/ 45 percent B, 35 minutes: method end (10 minutes equilibration before and after runs).

Analytical method 4: The experimental setup of Method 1 was used. The chromatography conditions were: flow rate 1 mL/min, solvent gradient (solvent A = water, solvent B = methanol) 0 minutes: 55 percent A/45 percent B, 20 minutes: 15 percent A/85 percent B, 25 minutes 10 percent A/90 percent B. Analysis - Internal Standard method using 0.0508 percent acetophenone in 60 percent methanol/water. Average relative standard deviations ranges from 1 to 2 percent, depending upon peak analyzed.

Analytical Method 5: The reaction mixture was diluted with acetonitrile to a concentration of 0.01-0.1 percent by weight of components and the diluted sample was analyzed by HPLC on a Waters NovaPak C18 column (10.16 cm x 0.635 cm inner diameter) connected to a Varian™ 9100 UV detector, set at 280 nm. The column temperature was 30°C, the pressure was 140 (14,000 kPa) at 0 minutes, the absorption full scale for the detector was 2.0, the integrator attenuation was 3 and the chart speed was 0.5 cm/minutes. The auto sampler injects 20 microliters of sample onto the column every 36 minutes. Reservoir A contained megapure water and reservoir B HPLC grade acetonitrile. The following protocol was used:

Time	Flow Rate	%B
(min)	(mL/min)	
0	1.0	40
8	1.0	40
20	1.0	60
26	1.0	99
30	1.0	40

The peak area generated by each component in the sample was used with its known response factor, and the dilution ratio, to calculate the concentrations of each component in the sample solution.

Fluorenone (Aldrich 98 percent), about 0.5 percent fluorene and methyl-fluorenes

Acetone (Baker reagent, dried over molecular sieves)

Diphenylmethane (Penta International, 99+ percent distilled grade)

Phenol (Dow Chemical 99+ percent), about 100 ppm H₂O + 100 ppm impurities

Sodium 3-mercaptopropanesulfonate: Source A: 90 percent purity (Aldrich)

Source B: 90 percent purity (Raschig Corp.)

3-Mercaptopropanesulfonic acid (MPSA):

Source A: Prepared from 90 percent Aldrich sodium
3-mercaptopropanesulfonate by reaction with HCl or treatment in an
ion-exchange column

Source B: Prepared from 90 percent Raschig Corp. sodium 3-
5 mercaptopropanesulfonate.

Sodium 2-mercaptoethanesulfonate: 98 percent (Aldrich)

4-Mercaptobutanesulfonic acid (MBSA): prepared from
1,4-butanedisulfone (Aldrich) by reaction with NaSH, Ba(SH)₂, or an alkali
metal thioacetate in accordance with R. Fischer, supra, A. Mustafa, supra,
10 or Chem. Abs., 90:86742m (1979).

2-Benzyl-4-mercaptobutanesulfonic acid: prepared from
1,4-butanedisulfone (Aldrich) and benzyl bromide in accordance with M. B.
Smith et al., "Lithium Aluminum Hydride-Aluminum Hydride Reduction of
Sulfones," J. Org. Chem., Volume 46 (1981), Pages 101-106 or T. Durst et
15 al., "Metallation of 5- and 6-membered ring sulfones," Can. J. Chem.,
Volume 47 (1969), Pages 1230-1233.

2,3-Dimercaptopropanesulfonic acid: prepared from sodium
2,3-dimercaptopropanesulfonate (Aldrich, 95 percent) by neutralization
with HCl or treatment with an acid ion-exchange resin, for example, DOWEX™
20 MSC-1, from The Dow Chemical Company.

2,2-Bis(mercaptomethyl)-1,3-propanedisulfonic acid: prepared from
2,2-bis(bromomethyl)-1,3-propanediol (Aldrich, 98 percent) as follows:

A mixture of 2,2-bis-(bromomethyl)-1,3-propanedisulfonic acid (200.0
g, 0.764 mol, 1.00 equivalent) and sodium sulfite (211.7 g, 1.68 mol, 2.20
25 equivalents) in 500 mL of deionized water was allowed to react under
reflux (108°C) for 28 hours. At this time, additional sodium sulfite
(105.9 g, 0.840 mol, 1.10 equivalent) was added and the mixture was
allowed to react for 3 additional days under reflux. At this point, the
mixture consists of a clear solution and a considerable amount of solids.

30 The mixture was cooled to room temperature and saturated with
gaseous hydrogen chloride. An exotherm to 43°C was observed. The mixture
becomes homogenous and yellow in color during the early stages of HCl
addition. As the mixture becomes saturated with HCl, a voluminous white
precipitate was formed. The solution was cooled to room temperature and
35 filtered to remove solid salts, which were primarily sodium chloride and
sodium bromide. Water was removed from the filtrate to provide 2,2-bis-

(hydroxymethyl)-1,3-propanedisulfonic acid (190.7 g) as a highly viscous amber oil (glass).

Alternatively, the reaction mixture can be worked up by dilution with 200 mL of ethanol or methanol, after which the solid was removed by filtration. Solvent was removed from the filtrate on a rotary evaporator, to produce a white solid containing mainly disodium 2,2-bis-(hydroxymethyl)-1,3-propanedisulfonate. Concentrated hydrochloric acid can be added to the solid product to give the soluble disulfonic acid, plus insoluble sodium chloride and sodium bromide.

p-Xylene (400 mL) was added to the 2,2-bis-(hydroxymethyl)-1,3-propanedisulfonic acid and the resulting two-phase mixture was heated under reflux (135°C to 150°C pot temperature) to remove water, produced by the dehydration, in the form of an azeotrope in a Dean-Stark trap. After 8 hours' heating under reflux, the mixture was allowed to cool to room temperature and the upper xylene phase was decanted from the lower viscous product phase. Water (300 mL) was added to the cooled, lower phase containing 2,2-bis-(hydroxymethyl)-1,3-propanedisulfonic acid bis-sultone to produce a large mass of white solid. The white solid (bis-sultone) was removed by filtration, slurry washed extensively with water and with methanol and dried in a vacuum oven

To a solution of sodium bicarbonate (9.6 g, 114 mmol, 2.6 equivalents) in 30 mL of water was slowly added thiolacetic acid (7.5 g, 96 mmol, 2.2 equivalents). The resulting solution of sodium thiolacetate was added to a solution of 2,2-bis-(hydroxymethyl)-1,3-propanedisulfonic acid bis-sultone (10 g, 43.8 mmol, 1.00 equivalent) in 280 g of acetonitrile. After all the thiolacetate was added, the resulting mixture was allowed to stand overnight at ambient temperature. Solvent was removed using a rotary evaporator to give 19.6 g of ring-opened bis-(thioacetate) adduct as a tan, flaky solid.

The thioacetate adduct (18.2 g) was hydrolyzed by stirring overnight at ambient temperature in a nitrogen-saturated mixture of 10 percent sodium hydroxide (20 g) and 100 g of water. The mixture was acidified to pH 3 with 10 percent aqueous hydrochloric acid solution. Solvent was removed from the resulting mixture in a fume hood, using a rotary evaporator. The residue was dissolved in 50 mL of water and saturated with hydrogen chloride gas. The resulting solid salt was removed by filtration and the filtrate was concentrated using a rotary evaporator to

give 2,2-bis-(mercaptomethyl)-1,3-propane-disulfonic acid as a viscous dark-colored oil.

Alternatively, the thioacetate adduct can be hydrolyzed by stirring with concentrated hydrochloric acid, removing the solid salt product by filtration and removing water from the filtrate using a rotary evaporator.

ABBREVIATIONS

nm = nanometers
uv = ultraviolet
rpm = revolutions per minute
10 mmol = millimoles
HPLC = high pressure liquid chromatography
BHPF = 9,9-bis-(4-hydroxyphenyl)fluorene = 4,4-isomer = BF
MPSA = 3-mercaptopropanesulfonic acid
MBSA = 4-mercaptobutanesulfonic acid
15 FN = Fn = 9-fluorenone
2,4-isomer = 9-(2-hydroxyphenyl)-9-(4-hydroxyphenyl)fluorene
DPM = diphenylmethane
BPA = 2,2-bis-(4-hydroxyphenyl)propane = bisphenol A
n/d = not determined
20 ~ = about or approximate

EXAMPLE 1

CONDENSATION OF 9-FLUORENONE WITH PHENOL: (3-MERCAPTOPROPANESULFONIC ACID)

9-Fluorenone (20.0 g, 0.111 mol, 1.0 equivalent) and molten phenol (156.7 g, 1.66 mol, 15.0 equivalents) were added to a 500 mL PFA Teflon™, material from DuPont, reactor (reactor design 1).

The reaction mixture was heated to 65°C with stirring at 300 to 350 rpm under a pad of nitrogen. 3-Mercaptopropane-sulfonic acid (0.864 g, 5.53 mmol, 0.0498 equivalents) was added slowly over approximately 1 minute to the reaction mixture at 65°C. The mixture turns dark yellow-orange upon adding the catalyst and gradually fades to a lighter yellow color as the reaction progresses. A slight exotherm to 66°C was observed. The exotherm persists for 10 minutes before the mixture cools to the reaction temperature of 65°C. The reaction was monitored throughout the reaction period by collecting samples and analyzing by HPLC (Analytical method 1).

The 9-fluorenone was found to be completely consumed within 120 minutes with a product composition, determined by quantitative HPLC, of 98

percent of 9,9-bis-(4-hydroxyphenyl)-fluorene. The product was further analyzed by a combination of HPLC and UV (282 nm) and contained:

	<u>% by area</u>	<u>product</u>
	96.9	9,9-bis-(4-hydroxyphenyl)fluorene (BHFF)
5	2.4	9-(2-hydroxyphenyl)-9-(4-hydroxyphenyl)-fluorene (2,4-isomer)
	0.7	adduct containing two fluorene units and three phenolic units (two:three adduct)

EXAMPLE 2

10 GENERATION OF 3-MERCAPTOALKANESULFONIC ACIDS FROM THEIR SODIUM SALTS IN THE REACTION MIXTURE

A. The procedure of Example 1 was repeated except that the catalyst was prepared *in situ* from 90 percent sodium 3-mercaptopropanesulfonate (0.854 g, 4.79 mmol, 0.0431 equivalents) and 95
15 to 98 percent sulfuric acid (0.48 g, 4.9 mmol, 0.044 equivalents) and the reaction was conducted at 85°C.

The 9-fluorenone was completely consumed between 60 and 120 minutes, giving a final isomer distribution, determined as in Example 1, of:

	<u>% by area</u>	<u>product</u>
20	95.3	4,4-isomer (BHFF)
	3.6	2,4-isomer
	1.1	two-three adduct

B. The procedure of Example 2A was repeated except that 98 percent sodium 2-mercaptoethanesulfonate (0.779 g, 4.75 mmol, 0.0427
25 equivalents) and 95 to 98 percent sulfuric acid (0.48 g, 4.9 mmol, 0.044 equivalents) were used as catalysts. The reaction was conducted at 85°C.

The 9-fluorenone was completely consumed within 60 minutes, giving a product isomer distribution, as described in Example 2A, of:

	<u>% by area</u>	<u>product</u>
30	91.7	4,4-isomer
	6.6	2,4-isomer
	1.7	two:three adduct

35 These experiments demonstrate that 2-mercaptoethane-sulfonic acid, generated in the reaction mixture, was an effective condensing agent for the process.

EXAMPLE 3

CONDENSATION USING SULFURIC ACID AND 3-MERCAPTOPROPIONIC ACID (COMPARATIVE EXAMPLE)

9-Fluorenone (20.0 g, 0.111 mol, 1.0 equivalent) and molten phenol (156.7 g, 1.66 mol, 15.0 equivalent) were added to the reactor (reactor design 1). The reaction mixture was heated to 65°C with stirring a pad of nitrogen. 3-Mercaptopropionic acid (0.588 g, 5.54 mmol, 0.0499 equivalent) was added to the reaction mixture at 65°C, followed by the slow addition (over 1 minute) of concentrated (95-98 percent) sulfuric acid (0.551 g, 5.62 mmol, 0.0506 equivalent) to the reaction mixture at 65°C. The mixture turns purplish-orange upon adding the sulfuric acid and gradually fades to a yellow-orange color within 5 to 10 minutes. A slight exotherm to 66 to 67°C, was observed.

The exotherm persists for 15 minutes before the reaction mixture cools to the reaction temperature of 65°C. The reaction was monitored throughout the reaction period by collecting samples and analyzing by HPLC. The 9-fluorenone was found to be completely consumed between 240 and 420 minutes. HPLC analysis (analytical method 3) gives product distribution:

<u>% by area</u>	<u>product</u>
93.0	9,9-bis-(4-hydroxyphenyl)fluorene
5.5	2,4-isomer
1.5	two:three adduct

This example shows that the prior art process was slower than the process of Examples 1 or 2 and that the resulting product contained less of the 4,4-isomer, than produced by the process of Examples 1 or 2.

EXAMPLE 4

EFFECT OF ADDED WATER IN FLUORENONE PHENOLATIONS USING MPSA (PHENOL AS SOLVENT)

A. 9-Fluorenone (138.1 g, 0.770 mol, 1.00 equivalent) and molten phenol (1500 g, 15.9 mol, 20.8 equivalent) was added to the reactor (reactor design 4, 2 L). The reaction mixture was heated to 45°C with stirring under a pad of nitrogen. 3-Mercaptopropanesulfonic acid (8.28 g, 53.0 mmol, 0.0692 equivalent) was added slowly over approximately 1 minute to the reaction mixture at 45°C. The reaction was monitored throughout the reaction period by collecting samples and analyzing by HPLC. The 9-fluorenone was found to be 22 percent consumed within 9 minutes, 52

percent consumed within 30 minutes, 76 percent consumed within 1 hour, 92 percent consumed within 1.75 hours, and 100 percent consumed within 3.5 hours. HPLC analysis (analytical method 3) gives the following relative area percent analysis for the reaction products at 100 percent

5 conversion:

<u>% by area</u>	<u>product</u>
96.9	9,9-bis(4-hydroxyphenyl)fluorene
2.4	2,4-isomer
0.6	two:three adduct

10 B. 9-Fluorenone (6.44 g, 0.0358 mol, 1.00 equivalent), molten phenol (70.0 g, 0.744 mol, 20.8 equivalent), and deionized water (1.93 g, 0.107 mol, 3.00 equivalent) was added to the reactor (reactor design 3). The reaction mixture was heated to 45°C with stirring under a pad of nitrogen. 3-Mercaptopropanesulfonic acid (0.385 g, 2.47 mmol, 0.0690

15 equivalent) was added slowly over approximately 1 minute to the reaction mixture at 45°C. The reaction was monitored throughout the reaction period by collecting samples and analyzing by HPLC. The 9-fluorenone was found to be 4 percent consumed within 9 minutes, 13 percent consumed within 1 hour, 29 percent consumed within 3.5 hours, and 94 percent consumed within

20 20.5 hours. HPLC analysis (analytical method 3) gives the following relative area percent analysis for the reaction products (fluorenone area not included) at 94 percent conversion:

<u>% by area</u>	<u>product</u>
96.5	BHPF (4,4-isomer)
2.9	2,4-isomer
0.6	two:three adduct

25 These experiments show that higher reaction rates and lower amounts of undesirable by-products were obtained, in the absence of additional water.

30 EXAMPLE 5

CONDENSATION OF FLUORENONE WITH PHENOL USING OTHER CONDENSING AGENTS

A. 4-MERCAPTOBUTANESULFONIC ACID

9-Fluorenone (82.9 g, 0.460 mol, 1.00 equivalent) and molten phenol (900 g, 9.56 mol, 20.8 equivalent) was added to the reactor (reactor

35 design 4, 2 L). The reaction mixture was heated to 45°C with stirring under a pad of nitrogen. 4-Mercaptobutanesulfonic acid (5.41 g, 31.8 mmol, 0.0692 equivalent) was added slowly over approximately 1 minute to

the reaction mixture at 45°C. The reaction was monitored throughout the reaction period by collecting samples and analyzing by HPLC. The 9-fluorenone was found to be 17 percent consumed within 5.5 minutes, 58 percent consumed within 30 minutes, 83 percent consumed within 1 hour, 95 percent consumed within 1.75 hours, and 100 percent consumed within 3.5 hours. HPLC analysis (analytical method 3) gives the following relative area percent analysis for the reaction products at 100 percent conversion:

	<u>% by area</u>	<u>product</u>
10	97.0	BHPF
	2.5	2,4-isomer
	0.5	two:three adduct

B. 2,2-BIS-(MERCAPTOMETHYL)-1,3-PROPANEDISULFONIC ACID

To a 4-dram vial (reactor design 2) was added a mixture of fluorenone (0.40 g, 2.22 mmol, 1.00 equivalent) and phenol (2.10 g, 22.3 mmol, 10.0 equivalent). The capped vial was placed into the heating control block regulated at 63°C and stirring began. 2,2-Bis(mercaptomethyl)-1,3-propanedisulfonic acid (0.029 g, 0.098 mmol, 0.044 equivalent) was added in one portion to the vial which was then tightly capped. The reaction was monitored throughout the reaction period by collecting samples and analyzing by HPLC. The 9-fluorenone was found to be 25 percent consumed in 1.5 hours. HPLC analysis (analytical method 2) gives the following relative area percent analysis for the reaction products (fluorenone area not included) at 25 percent conversion:

	<u>% by area</u>	<u>product</u>
25	95.7	BHPF
	3.4	2,4-isomer
	0.9	two:three adduct

C. 2,3-DIMERCAPTOPROPANESULFONIC ACID

To a 4-dram vial (reactor design 2) was added a mixture of fluorenone (0.40 g, 2.22 mmol, 1.00 equivalent) and phenol (2.10 g, 22.3 mmol, 10.0 equivalent). The capped vial was placed into the heating control block regulated at 63°C and stirring was begun. 2,3-Dimercaptopropanesulfonic acid (0.021 g, 0.011 mmol, 0.050 equivalent) was added in one portion to the vial which was then tightly capped. The reaction was monitored throughout the reaction period by collecting

samples and analyzing by HPLC (analytical method 2). The 9-fluorenone was found to be 5 percent consumed in 1.5 hours.

D. 3-MERCAPTOPROPIONIC ACID AND METHANESULFONIC ACID

(COMPARATIVE EXAMPLE)

5 To a 4-dram vial (reactor design 2) was added a mixture of fluorenone (0.460 g, 2.55 mmol, 1.00 equivalent) and phenol (5.00 g, 53.1 mmol, 20.8 equivalent). The capped vial was placed into the heating control block regulated at 55°C and stirring was begun.

3-Mercaptopropionic acid (0.0217 g, 0.204 mmol, 0.080 equivalent) and

10 methanesulfonic acid (0.0197 g, 0.205 mmol, 0.080 equivalent) were added in one portion to the vial which was then tightly capped. The reaction was monitored throughout the reaction period by collecting samples and analyzing by HPLC. The 9-fluorenone was found to be 32 percent consumed within 30 minutes, 51 percent consumed within 1 hour, and 71 percent

15 consumed within 2 hours. HPLC analysis (analytical method 3) gives the following relative area percent analysis for the reaction products (fluorenone area not included) at 71 percent conversion:

	<u>% by area</u>	<u>product</u>
	93.7	BHPF
20	5.5	2,4-isomer
	0.8	two:three adduct

E. 3-MERCAPTOPROPIONIC ACID AND METHYLSULFAMIC ACID (COMPARATIVE EXAMPLE)

25 To a 4-dram vial (reactor design 2) was added a mixture of fluorenone (0.460 g, 2.55 mmol, 1.00 equivalent) and phenol (5.00 g, 53.1 mmol, 20.8 equivalent). The capped vial was placed into the heating control block regulated at 55°C and stirring was begun.

3-Mercaptopropionic acid (0.0217 g, 0.204 mmol, 0.080 equivalent) and

30 methylsulfamic acid (Aldrich 98 percent) (0.0227 g, 0.204 mmol, 0.080 equivalent) were added in one portion to the vial which was then tightly capped. The reaction was monitored throughout the reaction period by collecting samples and analyzing by HPLC. The 9-fluorenone was found to be 13 percent consumed within 1 hour, and 21 percent consumed within 2

35 hours. HPLC analysis (analytical method 3) gives the following relative area percent analysis for the reaction products (fluorenone area not included) at 21 percent conversion:

<u>% by area</u>	<u>product</u>
95.4	BHPF
4.6	2,4-isomer
n/d	two:three adduct

5 F. SUBSTITUTION OF PHOSPHONIC ACIDS FOR METHANESULFONIC ACID
(COMPARATIVE EXAMPLES)

The reaction conditions described in Example 5D were repeated substituting each of the following acids (each at 8 mol percent) for methanesulfonic acid in the reaction: sulfamic acid (Aldrich 98 percent),
10 methylphosphonic acid (Aldrich 98 percent), and phenylphosphonic acid (Aldrich 98 percent). In each case, very little conversion of the fluorenone was observed in comparison with the use of methanesulfonic acid.

These examples demonstrate that mixtures of a mercapto-compound and
15 an acid were inferior to 3-mercaptopropane-sulfonic or 4-mercaptobutanesulfonic acid for catalyzing the condensation of phenol with fluorenone.

EXAMPLE 6

20 EFFECT OF WATER CONCENTRATION IN FLUORENONE PHENOLATIONS USING MPSA WITH
DIPHENYLMETHANE AS A CO-SOLVENT

A. 9-Fluorenone (3.65 g, 0.0200 mol, 1.00 equivalent), molten phenol (39.6 g, 0.420 mol, 20.8 equivalent), deionized water (0.055 g, 3.06 mmol, 0.151 equivalent) and diphenylmethane (32.83 g) was added to the reactor (reactor design 2). The reaction mixture was heated to 53°C
25 with stirring under a pad of nitrogen. 3-Mercaptopropanesulfonic acid (0.170 g, 1.10 mmol, 0.0537 equivalent) was added slowly over approximately 1 minute to the reaction mixture at 53°C. The reaction was monitored throughout the reaction period by collecting samples and analyzing by HPLC. The 9-fluorenone was found to be 49 percent consumed
30 within 2 hours and 77 percent consumed within 4.5 hours. HPLC analysis (analytical method 3) gives the following relative area percent analysis for the reaction products (fluorenone area not included) at 77 percent conversion:

	<u>% by area</u>	<u>product</u>
35	96.1	BHPF
	3.4	2,4-isomer
	0.5	two:three adduct

B. 9-Fluorenone (3.65 g, 0.020 mol, 1.0 equivalent), molten phenol (39.6 g, 0.420 mol, 20.8 equivalent), deionized water (0.362 g, 20.1 mmol, 0.994 equivalent) and diphenylmethane (32.83 g) was added to the reactor (reactor design 2). The reaction mixture was heated to 53°C with stirring under a pad of nitrogen. 3-Mercaptopropanesulfonic acid (0.158 g, 1.00 mmol, 0.0500 equivalent) was added slowly over approximately 1 minute to the reaction mixture at 53°C. The reaction was monitored throughout the reaction period by collecting samples and analyzing by HPLC. The 9-fluorenone was found to be 25 percent consumed within 2 hours, 45 percent consumed within 4.5 hours, and 57 percent consumed within 6 hours. HPLC analysis (analytical method 3) gives the following relative area percent analysis for the reaction products (fluorenone area not included) at 57 percent conversion:

	<u>% by area</u>	<u>product</u>
15	96.3	BHPF
	3.7	2,4-isomer
	n/d	two:three adduct

C. 9-Fluorenone (3.65 g, 0.0200 mol, 1.00 equivalent), molten phenol (39.6 g, 0.420 mol, 20.8 equivalent), deionized water (1.09 g, 60.7 mmol, 3.00 equivalent) and diphenylmethane (32.83 g) was added to the reactor (reactor design 2). The reaction mixture was heated to 53°C with stirring under a pad of nitrogen. 3-Mercaptopropanesulfonic acid (0.158 g, 1.00 mmol, 0.0500 equivalent) was added slowly over approximately 1 minute to the reaction mixture at 53°C. The reaction was monitored throughout the reaction period by collecting samples and analyzing by HPLC. The 9-fluorenone was found to be 11 percent consumed within 2 hours, 20 percent consumed within 4.5 hours, and 23 percent consumed within 6 hours. HPLC analysis (analytical method 3) gives the following relative area percent analysis for the reaction products (fluorenone area not included) at 23 percent conversion:

	<u>% by area</u>	<u>product</u>
	95.9	BHPF
	4.1	2,4-isomer
	n/d	two:three adduct

35 These examples show that addition of large amounts of water to the reaction mixtures retards the condensation reaction.

EXAMPLE 7REMOVAL OF WATER UNDER VACUUM WITH AND WITHOUT DIPHENYLMETHANE AS A
CO-SOLVENT

A. 9-Fluorenone (127.7 g, 0.709 mol, 1.00 equivalent) and molten
5 phenol (996.1 g, 10.58 mol, 14.9 equivalent) was added to the reactor
(reactor design 4, 3 L). The reaction mixture was heated to 45°C with
stirring under a pad of nitrogen. 3-Mercaptopropanesulfonic acid (5.53 g,
35.4 mmol, 0.0500 equivalent) was added slowly over approximately 1 minute
to the reaction mixture at 45 °C. The reaction was monitored throughout
10 the reaction period by collecting samples and analyzing by HPLC. The
9-fluorenone was found to be 60 percent consumed within 1 hour, 88 percent
consumed within 2 hours, and 95 percent consumed within 2.5 hours. HPLC
analysis (analytical method 2) gives the following relative area percent
analysis for the reaction products at 100 percent conversion:

	<u>% by area</u>	<u>product</u>
15	98.0	BHPF
	1.4	2,4-isomer
	0.7	two:three adduct

B. 9-Fluorenone (127.7 g, 0.709 mol, 1.00 equivalent) and molten
20 phenol (996.4 g, 10.59 mol, 14.9 equivalent) was added to the reactor
(using reactor design four (4), three (3) L reactor with a Dean-Stark
water separation trap and vacuum inlet attached in lieu of the nitrogen
inlet). The reaction mixture was heated to 45°C with stirring.
3-Mercaptopropanesulfonic acid (5.53 g, 35.4 mmol, 0.0500 equivalent) was
25 added slowly over approximately 1 minute to the reaction mixture at 45°C.
The reaction mixture was allowed to stir for 15 minutes at atmospheric
pressure, then vacuum was applied to the reactor. From this point on, the
reaction was conducted under reduced pressure conditions (<5 mm Hg) with
water/phenol distillate collected in the Dean-Stark trap. The reaction
30 was monitored throughout the reaction period by collecting samples and
analyzing by HPLC. The 9-fluorenone was found to be 68 percent consumed
within 1 hour, 98 percent consumed within 2 hours, and 100 percent
consumed within 2.5 hours. HPLC analysis (analytical method 2) gives the
following relative area percent analysis for the reaction products at 100
35 percent conversion:

<u>% by area</u>	<u>product</u>
98.1	BHPF
1.3	2,4-isomer
0.6	two:three adduct

C. 9-Fluorenone (191.5 g, 1.063 mol, 1.00 equivalent), molten phenol (1500 g, 15.9 mol, 15.0 equivalent) and diphenylmethane (156.7 g) were added to the reactor (reactor design 4, 3 L with a Dean-Stark water separation trap and vacuum inlet attached in lieu of the nitrogen inlet).

The reaction mixture was heated to 45°C with stirring.

3-Mercaptopropanesulfonic acid (8.27 g, 53.0 mmol, 0.0499 equivalent) was added slowly over approximately 1 minute to the reaction mixture at 45°C.

The reaction mixture was allowed to stir for 15 minutes at atmospheric pressure, then vacuum was applied to the reactor. From this point on, the

reaction was conducted under reduced pressure conditions (<5 mm Hg) with water/phenol distillate collected in the Dean-Stark trap. The reaction was monitored throughout the reaction period by collecting samples and analyzing by HPLC. The 9-fluorenone was found to be 20 percent consumed within 15 minutes, 80 percent consumed within 2 hours, 98 percent consumed within 3.5 hours, and 100 percent consumed within 6 hours. HPLC analysis (analytical method 2) gives the following relative area percent analysis for the reaction products at 100 percent conversion:

<u>% by area</u>	<u>product</u>
98.3	BHPF
1.2	2,4-isomer
0.5	two:three adduct

These results show that removal of water from the reaction mixtures, containing diphenylmethane solvent, was unnecessary. These results show that removing water from the reaction mixtures accelerated the rate of the phenolation reaction, but was not necessary for good reaction rates and conversions.

EXAMPLE 8

REACTION OF PHENOL WITH ACETONE TO PRODUCE BISPHENOL A USING MPSA CATALYST

A. To a 4-dram vial (reactor design 2) was added a mixture of acetone (0.11 g, 1.8 mmol, 1.0 equivalent) and phenol (2.40 g, 25.5 mmol, 14.0 equivalent). The capped vial was placed into the heating control block regulated at 62°C and stirring was begun. 3-Mercaptopropanesulfonic

acid (0.021 g, 0.13 mmol, 0.070 equivalent) was added in one portion to the vial which was then tightly capped. The reaction was monitored throughout the reaction period by collecting samples and analyzing by HPLC. The acetone was found to be approximately 70 percent consumed within 2 hours. HPLC analysis (analytical method 2) gives a relative area percent ratio of 97.0:3.0 for the desired reaction product 2,2-bis-(4-hydroxyphenyl)propane (4,4-bisphenol A) relative to the isomeric impurity 2-(2-hydroxyphenyl)-2-(4-hydroxyphenyl)-propane (2,4-bisphenol A) at 70 percent conversion.

B. To a 4-dram vial (reactor design 2) was added a mixture of acetone (0.11 g, 1.8 mmol, 1.0 equivalent) and phenol (2.40 g, 25.5 mmol, 14.0 equivalent). The capped vial was placed into the heating control block regulated at 25°C and stirring was begun. 3-Mercaptopropanesulfonic acid (0.074 g, 0.47 mmol, 0.25 equivalent) was added in one portion to the vial which was then tightly capped. The reaction was monitored throughout the reaction period by collecting samples and analyzing by HPLC. The acetone was found to be approximately 70 percent consumed within 2 hours. During the later stages of reaction, the reaction product begins to crystallize from the reaction mixture. HPLC analysis (analytical method 2) gives a relative area percent ratio of 98.9:1.1 for the desired reaction product 2,2-bis-(4-hydroxy-phenyl)propane (4,4-bisphenol A) relative to the isomeric impurity 2-(2-hydroxyphenyl)-2-(4-hydroxyphenyl)propane (2,4-bisphenol A) for the bulk reaction solution.

Separation of the crystalline product from the reaction mixture followed by rinsing of the crystals with water to remove surface impurities provides 4,4-bisphenol A product containing less than 500 parts per million of the 2,4-bisphenol A impurity.

C. (Comparative Example) To a 4-dram vial (reactor design 2) was added a mixture of acetone (0.11 g, 1.8 mmol, 1.0 equivalent) and phenol (2.40 g, 25.5 mmol, 14.0 equivalent). The capped vial was placed into the heating control block regulated at 62°C and stirring was begun. 3-Mercaptopropionic acid (0.014 g, 0.13 mmol, 0.070 equivalent) and methanesulfonic acid (0.013 g, 0.13 mmol, 0.070 equivalent) were added in one portion to the vial which was then tightly capped. The reaction was monitored throughout the reaction period by collecting samples and analyzing by HPLC. The acetone was found to be approximately 70 percent

consumed within 2 hours. HPLC analysis (analytical method 2) gives a relative area percent ratio of 96.2:3.8 for the desired reaction product 2,2-bis-(4-hydroxyphenyl)propane (4,4-bisphenol A) relative to the isomeric impurity 2-(2-hydroxyphenyl)-2-(4-hydroxy-phenyl)propane (2,4-bisphenol A) at 70 percent conversion.

These experiments show that MPSA gives a product, with a higher 4,4-isomer ratio than prior art catalysts.

EXAMPLE 9

PREPARATION OF THE POLYMER-SUPPORTED MERCAPTOSULFONIC ACID CATALYST (PMBSA)

A. PREPARATION OF SULTONE INTERMEDIATE

1,4-Butanesultone (3.00 g, 22.0 mmol, 1.00 equivalent) was added to dry THF (150 mL) under a nitrogen atmosphere. The solution was cooled to -78°C using a dry ice/acetone bath. n-Butyllithium (1.6 molar in hexanes, 13.8 mL, 1.00 equivalent) was added slowly dropwise to the -78°C solution via an addition funnel over approximately 40 minutes with vigorous stirring. The homogeneous reaction mixture was allowed to stir for an additional 10 to 15 minutes at -78°C. Poly(vinylbenzylchloride) (3.3 g, approximately 1.0 equivalent of chloromethyl groups, 60/40 mixture of 3- and 4-isomers, Aldrich Chemical Co.) in dry THF (10 mL) was added over approximately 2 minutes to the reaction mixture at -78°C. The reaction mixture was allowed to slowly warm to room temperature in the cooling bath over approximately 3 hours. A white precipitate forms in the reaction mixture during the reaction period and remains as a solid as the mixture reaches room temperature. Water (100 mL) was added to the reaction mixture and the white (insoluble) solid was removed by filtration under vacuum. The solid was slurry-washed with water, then with small volumes of methanol and methylene chloride and dried in a vacuum oven, providing 4.77 g of a white solid sultone-functional polymer.

B. CONVERSION OF THE SULTONE-FUNCTIONAL POLYMER TO POLYMER-SUPPORTED MERCAPTOSULFONIC ACID (PMBSA)

The sultone-functional polymer from above (4.00 g, approximately 15.9 mmol sultone) was added to THF (125 mL). Potassium thioacetate (2.20 g, 19.0 mmol, 1.20 equivalent) was added as a solid to the slurry of the polysultone in THF. One drop of 50 percent tetrabutylammonium chloride was added to the rapidly stirred slurry. The temperature rose to 26°C over several minutes, then slowly dropped to 20°C. Two additional drops of 50

percent tetrabutylammonium chloride were added and the solution was warmed to 40°C for 15 minutes. Water (100 mL) was slowly added over 1 hour to the reaction mixture at 40°C. Substantial solid remains in the mixture at all stages of the reaction. The water/THF reaction mixture was allowed to
5 react 15 hours at 40°C. The solvent was removed by rotary evaporation and the resultant solid was ground to a fine powder. THF (125 mL) was again added to the solid, forming a slurry. Additional potassium thioacetate (2.20 g, 19.0 mmol, 1.20 equivalent) was added, resulting in an exotherm to 26°C. Several drops of 50 percent tetrabutylammonium chloride were
10 added and the reaction mixture was heated to 40°C for 15 hours. The solvent was removed by rotary evaporation. The tan solid was slurried in a 2:1 (by volume) mixture of toluene/ethanol. Concentrated hydrochloric acid (50 mL) was added and the mixture was stirred at room temperature overnight. Most of the HCl was removed by sparging the mixture with
15 nitrogen, then the solvents were removed by rotoevaporation. The light tan solid was slurry-washed extensively with 10 percent hydrochloric acid and with water. Drying overnight in a vacuum oven (60°C/full vacuum) provides 4.18 g of the polymer-supported mercaptosulfonic acid as a light tan solid.

20 C. PREPARATION OF A GEL PMBSA CATALYST (PMBSA-MER)

A catalyst was prepared as above, starting with Merrifield® resin (200 to 400, 2 percent crosslinked, gel), treated with butanesultone. The product was identified as PMBSA-MER.

25 D. PREPARATION OF CATALYST FROM BROMOMETHYLATED MACROPOROUS POLYSTYRENE (PMBSA-XEBR)

A catalyst was prepared as above, starting with bromomethylated Amberlite™ XE-305 macroporous resin (4 percent crosslinked, 20 to 50 mesh, 3.7 meq Br/g).

30 E. PREPARATION OF CATALYST FROM CHLOROMETHYLATED MACROPOROUS POLYSTYRENE (PMBSA-XECL)

A catalyst was prepared as above, starting with chloromethylated Amberlite™ macroporous resin (4 percent crosslinked, 20 to 50 mesh, 4.3 meq Cl/g).

35 F. PREPARATION OF CATALYST FROM MERRIFIELD® RESIN AND 1,3-PROPANESULTONE (PMPA-MER)

Catalyst was prepared above, by treating Merrifield® resin (2 percent crosslinked, 200 to 400 mesh, 4.3 meq Cl/g) with lithiated 1,3-

propanesultone, which can be prepared in accordance with T. Durst et al., "A new route to 5- and 6-membered ring sultones", Can. J. Chem., Volume 48 (1970), Pages 845-851.

EXAMPLE 10

5 EVALUATION OF A MERCAPTOSULFONIC ACID POLYMER (PMBSA) IN THE REACTION OF PHENOL WITH FLUORENONE

A. To a 4-dram vial equipped with a stirring bar (reactor design 2) was added 4.33 g of a 20.8:1 mole ratio mixture of phenol to fluorenone and 0.26 g [(6 percent by weight of the reactant solution)] of the
10 mercaptosulfonic acid polymer (PMBSA) prepared as in Example 9B. The reaction mixture consisted of a homogeneous liquid phase plus a separate heterogeneous polymer catalyst phase. The mixture was heated to 36°C for 3 hours. To increase the rate of reaction, the temperature was increased to 50°C for 18 hours. Monitoring of the reaction by HPLC shows some reaction
15 at 36°C and 100 percent conversion after 18 hours at 50°C. HPLC analysis (analytical method 2) gives the following relative area percent analysis for the products after 18 hours of reaction (100 percent conversion):

	<u>% by area</u>	<u>product</u>
	98.86	BHPF
20	0.98	2,4-isomer
	0.16	two:three adduct

B. (Comparative Example) DOWEX™ 50WX4 (a crosslinked sulfonated polystyrene resin, from The Dow Chemical Company) promoted with 2,2-dimethylthiazolidine (25 percent of the resin sulfonic acid
25 equivalents) was washed on a glass filter frit with phenol at 55°C to remove water. The resin was then washed with a mixture consisting of a 20.8:1 mole ratio mixture of phenol to fluorenone at 55°C to displace the original phenol wash. To a 4-dram vial equipped with a stirring bar (reactor design 2) was added 2.13 g of a 20.8:1 mole ratio mixture of
30 phenol to fluorenone and 0.74 g (35 percent by weight of the reactant solution) of the promoted DOWEX™ 50WX4, from The Dow Chemical Company, catalyst activated as described above. The weight of catalyst used was determined after the reaction by recovery of the resin from the reaction mixture by filtration, washing the resin with toluene and hexane, and
35 drying to a constant weight in a vacuum oven at 50°C for 6 hours.

The reaction mixture consisted of a homogeneous liquid phase plus a separate heterogeneous polymer catalyst phase. The mixture was heated to

50°C for 18 hours. Monitoring of the reaction by HPLC showed approximately 17 percent conversion after 4 hours and 73 percent conversion after 18 hours at 50°C. HPLC analysis (analytical method 2) and gave the following relative area percent analysis for the products after 18 hours of reaction

5 (73 percent conversion):

<u>% by area</u>	<u>product</u>
91.32	BHPF
6.78	2,4-isomer
1.90	two:three adduct

10 C. (Comparative Example) To a 4-dram vial equipped with a stirring bar (reactor design 2) was added 2.16 grams of a 20.8 : 1 mole ratio mixture of phenol to fluorenone and 0.34 g (16 percent by weight of the reactant solution) of dry Amberlyst™ 15 (a crosslinked sulfonated polystyrene resin from Rohm and Haas Company). The reaction mixture

15 consisted of a homogeneous liquid phase plus a separate heterogeneous polymer catalyst phase. The mixture was heated to 50°C for 18 hours. Monitoring of the reaction by HPLC showed approximately 24 percent conversion after 4 hours and 64 percent conversion after 18 hours at 50°C. HPLC analysis (analytical method 2) and gave the following relative area

20 percent analysis for the products after 18 hours of reaction (64 percent conversion):

<u>% by area</u>	<u>product</u>
95.82	BHPF
3.93	2,4-isomer
0.25	two:three adduct

25

These experiments showed that use of the catalysts disclosed herein gave higher conversions of fluorenone and higher 4,4/2,4-isomer ratios than the prior art catalysts.

EXAMPLE 11

30 RECOVERY AND RECYCLING OF SOLID CATALYST (PMBSA)

A. CATALYST RECOVERY

The reaction mixture from Example 10A was cooled to 40°C and the mixture was centrifuged. The upper liquid layer was decanted and additional warm (40 to 45°C) 20.8:1 mole ratio phenol/fluorenone solution (approximately 3

35 to 4 times the catalyst volume) was added. The mixture was stirred, centrifuged, and the warmed liquid layer was decanted. This wash procedure was repeated for a total of three washes, then the required

amount of phenol/fluorenone reactant mixture was added and the reaction began.

B. FIRST RECYCLE

To the 4-dram vial containing the mercaptosulfonic acid polymer recovered (as described above) from Example 11A was added 4.33 grams of a 20.8:1 mole ratio mixture of phenol to fluorenone. The mixture was heated to 50°C for 4 hours. Monitoring of the reaction by HPLC showed approximately 90 percent conversion after 4 hours at 50°C. HPLC analysis (analytical method 2) and gave the following relative area percent analysis for the products after 4 hours of reaction (90 percent conversion):

	<u>% by area</u>	<u>product</u>
	98.77	BHPF
15	1.09	2,4-isomer
	0.14	two:three adduct

C. SECOND RECYCLE

To the 4-dram vial containing the mercaptosulfonic acid polymer recovered (as described above) from the first recycle was added 4.00 grams of a 20.8:1 mole ratio mixture of phenol to fluorenone. The mixture was heated to 50°C for 18 hours. Monitoring of the reaction by HPLC shows approximately 83 percent conversion after 4 hours and 100 percent conversion after 18 hours at 50°C. HPLC analysis (analytical method 2) gives the following relative area percent analysis for the products after 18 hours of reaction (100 percent conversion):

	<u>% by area</u>	<u>product</u>
	98.79	BHPF
	1.10	2,4-isomer
	0.11	two:three adduct

D. THIRD RECYCLE

To the 4-dram vial containing the mercaptosulfonic acid polymer recovered (as described above) from the second recycle added 2.00 grams of a 20.8:1 mole ratio mixture of phenol to fluorenone. The mixture was heated to 40°C for 18 hours. Monitoring of the reaction by HPLC shows approximately 90 percent conversion after 4.5 hours and 100 percent conversion after 18 hours at 40°C. HPLC analysis (analytical method 2)

gives the following relative area percent analysis for the products after 18 hours of reaction (100 percent conversion):

	<u>% of area</u>	<u>product</u>
	99.08	BHPF
5	0.92	2,4-isomer
	* two:three adduct	
	* not detectable	

These experiments showed that the catalyst can be recycled repeatedly without loss of activity.

10 EXAMPLE 12

COMPOSITE EXPERIMENTAL DETERMINATION OF PARAMETERS FOR THE CONDENSATION OF PHENOL WITH FLUORENONE (3-MPSA, DIPHENYL-METHANE)

Experiments were run in stirred isothermal batch reactors (reactor designs 2 or 3) to determine the effect of temperature, molar ratios of reactants and amount of MPSA on reaction rates and product distribution. 15 Results were shown in Table I.

Graphical analysis of the results in Table I shows that formation of 2,4-BHPF was related to the reaction temperature. As the temperature increased, the 2,4/4,4 ratio increases. In contrast, the phenol/Fn mole ratio has little effect on the 2,4/4,4 ratio. The yield of 2:3 adduct increases markedly as the ratio of phenol/Fn decreases from 15:1 to 2.5:1 and the reaction temperatures was increased from 25°C to 85°C. 20

Graphical analysis of results for runs at 18 mole percent of MPSA, in terms of initial reaction rates (BHPF moles/L*hr) showed a marked rate increase in going from 25°C to 85°C. 25

Increasing the concentration of MPSA catalyst also gives the expected increase in the reaction rate. The phenol:fluorenone ratio also affects the reaction rate. It was believed that higher ratios of phenol to fluorenone were beneficial for condensations, run in a solvent, such as diphenylmethane. 30

TABLE I

PHENOL + Fn -----> BHPF

Catalyst MP5A, 10% Fn in DPM

5 Analytical Method 2 - UV Detector

Run #	Temp. (°C)	Mole Ratio	Mole% MP5A	2,4/4,4 Area	2:3/4,4 Area	Conv. (%)	Initial Rates*
1	55	8.62	12.8	0.0261	0.0198	99	0.16
2	25	2.46	7.9			14	0.0002
10 3	85	2.46	7.9	0.0389	0.114	62	0.047
4	25	14.75	7.9			12	0.028
5	85	14.75	7.9	0.0299	0.0098	99	0.53
6	25	2.46	17.7			5	0.001
7	85	2.46	17.7	0.0334	0.102	67	0.59
15 8	25	14.75	17.7	0.0202	0.0074	99	0.041
9	85	14.75	17.7	0.0317	0.0106	99	0.88
10 10	25	8.62	12.8	0.0239	0.0179	99	0.0042
11	85	8.62	12.8	0.0354	0.0244	99	0.73
12	55	2.46	12.8	0.0252	0.0673	57	0.035
20 13	55	14.75	12.8	0.0237	0.0076	99	0.17
14	55	8.62	7.9	0.0264	0.0177	99	0.12
15	55	8.62	17.7	0.0291	0.0248	99	0.42
16	55	8.62	12.8	0.0285	0.0185	99	0.15
17	63	14.75	12.8	0.026	0.00911	99	
25 18	63	14.75	12.8	0.0259	0.0088	99	
19	63	14.75	12.8	0.026	0.0088	99	
20	63	14.75	12.8	0.0266	0.0084	99	0.29
21**	63	14.75	12.8	0.0272	0.0096	99	
22	63	14.75	12.8	0.0265	0.0098	98	
30 23	63	14.75	12.8	0.0269	0.0092	98	
24	55	14.75	17.7	0.0255	0.0084	98	0.36
25	55	2.46	17.7	-	-	24	0.14
26	63	9.9	5	0.0258	0.015	98	0.078
27	25	14.75	12.8	0.0178	0.0067	98	0.013

35

Footnotes to Table I:

BF = BHPF (4,4-isomer)

2:3 = two:three adduct

*BHPF moles/L hr.

40 ** recycle

TABLE II

PHENOL + Fn -----> BHPF
 Catalyst MPSA, Various % Fn in Solvents
 Analytical Method 2 - UV Detector

Run	Temp °C	Solvent	% Fn*	Mole Ratio	Mole% MPSA	2,4/4,4 Area	2:3/4,4 Area	Time hr	% Conv
1	65	DPM	21	10	18	0.029	0.017	2	98
2	55	DPM	55	15	6.5	0.012	0.008	4	100
3	33	DPM	38.4	30	11.5	0.013	0.005	2.5	95
4	45	DPM	55	20.8	14.6	0.016	0.006	2	100
5	45	DPM	55	15	5.0	0.013	0.005	6	100
1A	27	DPM/MC	29	21	4.6	0.010	0.005	19.5	100
2A	35	MBenzoate	~55	21	8	0.015	0.004	6.5	86
3A	35	ClBenzene	13	21	25.6	0.018	0.005	3.25	99
4A	35	2,4,6TMPH	14	21	14.6	0.014	0.002	3	38

*In solvent

DPM = diphenylmethane

DPM/MC = diphenylmethane + methylene chloride

MBenzoate = methyl benzoate

ClBenzene = chlorobenzene

2,4,6TMPH = 2,4,6-TrimethylPhenol

The results in Table I showed that the 2,4/4,4 ratio stays constant as conversion increases, whereas the 2:3/4,4 ratio increases.

The amount of MPSA catalyst were related to the amount of 2,4-isomeric product formed. High 2,4/4,4 ratios at high concentrations of MPSA were probably related to a shift toward an acid-catalyzed reaction to produce relatively higher amounts of 2,4-isomer.

EXAMPLE 13

EFFECTS OF SOLVENTS ON PRODUCT DISTRIBUTION AND CONVERSIONS

Experiments were run in stirred tank batch reactors to determine whether use of a solvent was advantageous. Results of these experiments were shown in Table II. The use of a solvent does not appear to be advantageous. Comparison of a run using 10 percent DPM with neat run, at the same MPSA concentration, showed that reaction rates were higher for the neat run, although the DPM run uses 2.5 times more catalyst/Fn.

Higher 2,4/4,4 and 2:3-adduct ratios for the reactions in DPM was another disadvantage. It was therefore preferred to run the condensations in excess phenol as solvent.

EXAMPLE 14

EFFECTS OF TEMPERATURE, MPSA CONCENTRATION AND PHENOL/FLUORENONE RATIOS ON
PRODUCT DISTRIBUTIONS (EXCESS PHENOL AS SOLVENT)

5 Reactions were done in isothermal stirred tank reactors as described
above. Results were presented in Table III. These results demonstrate
that increasing the amount of catalyst increased the 2,4/4,4 isomer ratio.
Increasing the reaction temperature or decreasing the phenol/Fn mole ratio
leads to higher amounts of 2:3 adduct in the product mixture.

EXAMPLE 15

10 RECOVERY AND RECYCLING OF MPSA FROM THE REACTION MIXTURES

Runs of 100 mL to 1.5 L (reactor designs 3 and 4) were done to
determine whether MPSA can be extracted from the neat BHPF reaction
solution with water and recycled to subsequent runs. The effect of
stirrer rpm on the time required for breaking a resulting emulsion were
15 also investigated.

Phenol was weighed and charged into the reaction vessel. Fluorenone
was weighed and charged to the reaction vessel, followed by a weighed
quantity of MPSA catalyst.

TABLE III

PHENOL + Fn -----> BHPF

Catalyst MPSA, Neat Reactions - no solvent

Analytical Method 2 - UV Detector

5	Run	Temp.	Mole	Mole %	Time	2,4/4,4	2:3/4,4%	%	MPSA
	#	(°C)	Ratio	MPSA	(hr.)	Area	Area	Conv.	**
10	1	65	10	5	2.2	0.017	0.011	99	0.0470
	2	35	2	8	3	0.013	0.003	98	0.0382
	3	55	21	8	1.5	0.016	0.004	100	0.0382
	4	63	10	2	7.5	0.014	0.008	97	0.0187
	5	63	15	13	1	0.017	0.005	-	0.0846
	6	28	10	5	20	0.011	0.008	92	0.0470
	7	45	10	5	5	0.012	0.007	91	0.0470
15	8 ¹	36	21	8	5	0.013	0.005	62	
	9	36	21	3.9	7.25	0.012	0.005	95	0.0191
	10 ²	36	21	4	6.5	0.012	0.007	96	0.0202
	11	35	21	159	1.83	0.028	0.011	100	0.6932
20	12*	45	15	5	2.5	0.013	0.006	99	0.0330
	13	45	15	5	3.5	0.014	0.007	100	0.0330
	14*	55	21	3	2	0.014	0.006	99	0.0146
	15 ³	35	21	18 mpa	20	0.034	0.011	100	0.0580

5.2 msa

* = vacuum used to remove water during reaction.

** moles/L

25

¹ Molecular sieves used to remove water while reaction was taking place + more catalyst was added.

² Fn added continuously over 43 min.

³ MSA (methanesulfonic acid) and MPA (mercaptopropionic acid) used instead of MPSA

The concentrations of materials in the resulting mixtures were followed by HPLC (Analytical Method 4).

The following mixtures were used:

5	<u>Neat Runs</u>		<u>DPM Runs</u>	
	<u>Chem.</u>	<u>wt% theory</u>	<u>Chem.</u>	<u>wt% theory</u>
	Phenol	82.35	Phenol	47
	Fn	0.00	Fn	0.00
	MPSA	0.50	MPSA	0.21
	H ₂ O	0.84	H ₂ O	0.48
10	BHPF	16.31	BHPF	9.3
			DPM	43

To the reactor was added 200 mL of the mixture and 200 mL of water. The resulting mixture was stirred for 10 minutes. The phases were allowed to separate and the separation time noted. A sample (10 mL) of the organic phase was removed for analysis by HPLC and I. C. (ion chromatography). The aqueous phase was retained for analysis.

The extraction of the remaining organic layer was repeated, using an equal volume of water (190 mL). At the end of the extraction and separation, 10 mL of the organic layer was retained.

The remaining 180 mL of organic layer was extracted with 180 mL of water. A 10-mL sample of the organic layer was retained, as before.

The aqueous extract was distilled under vacuum to give a solution of phenol, MPSA and small amounts of BHPF. Acid titration and I.C. analysis indicated that all of the MPSA was recovered from the mixtures. Results of representative extractions were given in Table IV.

Table IV
Extraction Data for Neat 21:1 (Phenol/Fn) Run
(500 rpm Stirring Rate)

Extraction	1		2		3	
	Org.	Aq.	Org.	Aq.	Org.	Aq.
5 Phase	217	200	251.4	190	216.2	180
g. used	262.2	154.9	226.9	214.5	196.4	199.8
g. end						
% Component in Phase						
Phenol	62.8	6.71	57.6	6.63	59.2	6.39
10 Fn	0.00	0.0	0.00	0.0	0.00	
MPSA	0.08	0.55	0.030	0.12	0.0100	0.039
H ₂ O	23.7	92.7	28.0	93.3	25.1	93.6
BHPF	13.4	0.0098	14.4		15.8	0.0073
(150 rpm Stirring Rate)						
Extraction	1		2		3	
	Org.	Aq.	Org.	Aq.	Org.	Aq.
15 Phase	217	200	258	190	226.4	180
g. used	268.6	148.4	237.2	200.5	195.36	200.6
g. end						
% Component in Phase						
20 Phenol	60.1	6.37	61.6	7.17	61.1	6.82
Fn	0.00	0.0	0.00	0.0	0.00	
MPSA	0.10	0.53	0.0270	0.10	-0.005	0.03
P-1 H ₂ O	27.1	93.1	24.2	92.7	23.5	93.2
25 P-2 BHPF	12.7	0.0088	14.3	-	15.4	-

** 4th and 5th extractions: equal volumes of organic and water layers: MPSA in organic 0.0030 (4th), 0.0005 (5th), in water 0.0143 (4th), 0.0025 (5th)

EXAMPLE 16

30 ISOMERIZATION STUDY IN THE PRESENCE OF MPSA

Reactions were done in stirred batch isothermal reactors (reactor design 2). To the reactor was charged a mixture of 83.2 percent by weight of phenol, 0.09 percent by weight of fluorenone, 13.2 percent by weight of BHPF, containing 0.92 percent by weight of 2,4-isomer and 0.68 percent by weight of 2:3 adduct. Various amounts of MPSA were charged to the reactor. The resulting mixtures were stirred and heated. The compositions in the reactor at various times were determined by analytical method 4.

Compositions of other reaction mixtures were given in Table V.
 40 Results were given in Table VI.

These results showed that heating mixtures, in the presence of MPSA, brings about isomerization of the reaction mixtures toward higher concentrations of 9,9-bis-(4-hydroxyphenyl)-fluorene. The concentration of higher adducts also increases as a result of prolonged heating.

5

TABLE V
COMPOSITIONS FOR ISOMERIZATION STUDY

		Temp	mole/L	mole/L	g Rx	g
	<u>Run</u>	<u>°C</u>	<u>MPSA</u>	<u>Phenol</u>	<u>Mix</u>	<u>MPSA</u>
10	1	70	0.642	9.250	5.42	0.5710
	2	55	0.340	9.705	5.42	0.2878
	4	55	0.920	8.835	5.42	0.8540
	6	55	0.642	9.250	5.42	0.5710
	8	70	0.340	9.705	5.42	0.2878
15	9	70	0.920	8.835	5.42	0.8540
	15	55	0.180	9.940	5.42	0.1520

TABLE VI
ISOMERIZATION STUDIES

		Time	Phenol	Fn	% in Reaction Mixture			2nd add.*	% Total ⁺	Total*
					BHPF	2:4*	2:3*			
5	<u>Run 1</u>	0	75.27	0.08	11.94	1.74	0.62	0.00	89.6	99.2
	S#1	4	76.86	0.00	13.09	1.61	0.26	0.018	91.8	101.4
	S#2	22.5	74.64	0.00	14.05	1.01	0.17	0.15	90.0	99.5
	S#3	52	76.18	0.00	14.30	0.88	0.14	0.23	91.71	01.3
10	<u>Run 2</u>	0	79.00	0.09	12.66	1.84	0.65	0.00	94.2	99.3
	S#1	4	81.9	0.0	13.1	1.9	0.5	0.00	97.4	102.5
	S#2	21	76.71	0.00	13.21	1.56	0.29	0.0242	91.76	96.8
	S#3	29	80.41	0.00	14.07	1.53	0.23	0.0169	96.25	101.3
15	S#4	94	80.96	0.00	14.18	0.89	0.14	0.07	92.17	101.2
	S#5	101	77.22	0.00	14.62	0.94	0.21	0.10	92.99	98.0
	<u>Run 4</u>	0	71.88	0.08	11.52	1.66	0.59	0.00	85.7	99.3
	S#1	2	67.53	0.06	12.25	1.68	0.40	0.00	81.92	95.5
20	S#2	4.5	69.3	0.0	12.2	1.5	0.3	0.013	83.3	96.9
	S#3	24.5	74.49	0.07	13.18	0.95	0.15	0.04	88.88	102.5
	S#4	88	67.54	0.00	13.95	0.70	0.11	0.22	82.29	95.9
	<u>Run 6</u>	0	76.02	0.08	12.06	1.75	0.62	0.00	90.5	100.1
25	S#1	2	73.72	0.00	13.01	1.83	0.51	0.00	89.0	98.6
	S#2	4.5	75.4	0.0	13.2	1.8	0.4	0.0	90.8	100.3
	S#3	24.5	78.39	0.00	13.36	1.17	0.18	0.02	93.13	102.7
	S#4	88	74.06	0.00	14.99	0.76	0.10	0.12	89.90	99.4
30	<u>Run 8</u>	0	84.03	0.09	13.33	1.94	0.69	0.00	100.1	105.1
	S#1	7	78.92	0.00	14.00	1.69	0.29	0.00	94.90	99.0
	S#2	23	76.1	0.00	14.6	1.2	0.2	0.1	92.2	97.2
	S#3	52	79.09	0.00	14.92	1.02	0.15	0.12	95.30	100.3
35	<u>Run 9</u>	0	72.59	0.08	11.52	1.68	0.59	0.00	86.5	100.1
	S#1	3	68.42	0.00	12.90	1.31	0.20	0.03	82.87	96.5
	S#2	7	70.5	0.0	13.2	1.0	0.2	0.1	84.8	98.4
	S#3	22.5	70.86	0.00	12.99	0.76	0.16	0.19	84.95	98.6
40	<u>Run 15</u>	0	80.93	0.09	12.97	1.87	0.66	0.00	96.5	99.1
	S#1	2	83.36	0.00	13.83	2.01	0.66	0.00	99.8	102.6

* estimated

+ including catalyst

EXAMPLE 17**PURIFICATION OF 9,9-BIS-(4-HYDROXYPHENYL)FLUORENONE****A. PRECIPITATION FROM METHYLENE CHLORIDE**

A synthetic reaction mixture (105.5 g: 63 percent by weight, 66.5 g of phenol; 20 percent by weight, 21.1 g of 4,4-BHPF and 17 percent by weight, 18 g of water) was placed in a 500-mL round-bottom three-neck flask equipped with a heating mantle/Variac, thermometer, stirring bar and distillation arm. A "Therm-O-Watch" was used to control temperature of the liquid in the flask. A separate thermometer was placed in the distillation tower to monitor temperature in the vapor phase.

The mixture was stirred and heated at ambient pressure up to a temperature of 160°C, during which time distillation of phenol and water occurred. Analysis of the reaction mixture indicates the phenol:BHPF mass ratio was 1:1. The reaction mixture, while still hot, was slowly added to 176 g of BHPF-saturated methylene chloride and the resulting mixture was slowly swirled to produce a homogeneous solution, clear and yellow in color. The mixture was allowed to cool to room temperature which causes crystallization to occur.

The rod-like crystals present in the magma were analyzed by microscope prior to filtration. Approximately 80 percent of the crystals viewed were longer than 100 microns and have a diameter between 20 and 50 microns.

The crystal magma was filtered on a medium porosity glass frit, using a vacuum produced by water jet. The filter cake was displacement-washed with 79 g of BHPF-saturated methylene chloride and then 72 g of hot (90°C) water. After drying at 65°C in air overnight, 12.9 g of white product was recovered. Isolated yield was 61 percent and HPLC purity was 99.8 percent.

B. WASHING WITH SODIUM BICARBONATE SOLUTION

Synthetic reaction mixture (105.5 g as in Example 17A) was combined with 100 mL of a 2 percent by weight aqueous solution of sodium bicarbonate. The mixture was agitated and then the organic and aqueous layers were allowed to separate in a separatory funnel. The organic layer was drawn off. This process was performed a total of 4 times. Washed reaction mixture (85.2 g: 58 percent, 58 g of phenol; 17.4 percent, 17 g of 4,4-BHPF and 25 percent, 21 g of water) was placed in the apparatus, described in Example 17A.

The mixture was stirred and heated at a pressure of 80 to 100 mm Hg, up to a temperature of 160°C, during which time distillation of phenol and water occurred. BHPF-saturated phenol (100 g) was then added to the reaction mixture and the temperature of the mixture was controlled at 65°C. Crystallization began within 1 hour. The slurry was stirred overnight, after which the rod-like crystals present in the magma were analyzed by microscope before filtration. Approximately 30 percent of the crystals viewed have a length greater than 100 microns and a diameter between 10 and 30 microns.

The crystal magma was filtered on a medium porosity glass frit using a vacuum produced by a water jet. The brown filter cake was displacement-washed with 200 mL of room-temperature water and then stirred with the same amount of water. The brown/beige crystals were then washed with BHPF-saturated methylene chloride and then with ethylene dichloride. After drying at 65°C in air overnight, 7 g of brown product were recovered. The isolated yield was 47 percent and HPLC purity was 99.7 percent.

C. DISTILLATION OF PHENOL, CRYSTALLIZATION FROM TOLUENE

Synthetic reaction mixture (149 g: 17.5 percent by weight, 24 g of 4,4-BHPF; 95 g of phenol and 30 g of water) were charged to the reactor, described in Example 17A. The mixture was stirred and heated at a pressure of 80 to 100 mm Hg up to a temperature of 160°C, during which time distillation of phenol and water occurred until the phenol:BHPF mass ratio was reduced to approximately 1:1. There was no increase in adduct concentration.

The resulting mixture was added while still hot, to 121 g of BHPF-saturated toluene. The resulting homogeneous solution was allowed to cool to room temperature, during which crystallization occurred. The resulting rod-like crystals present in the magma were analyzed by microscope prior to filtration. Approximately 20 percent of the crystals viewed had a length greater than 100 microns and a diameter between 10 and 50 microns.

The crystal magma was filtered on a medium porosity glass frit using a vacuum produced by a water jet. The pink filter cake was treated similarly to other examples. After drying at 65°C in air overnight, 18.5 g of pink product were recovered. Isolated yield was 77 percent and HPLC purity was 98.1 percent.

D. DISTILLATION OF PHENOL; CRYSTALLIZATION FROM METHYLENE CHLORIDE

Phenol and fluorenone were combined in the presence of 3-mercaptopropanesulfonic acid (MPSA) to produce a reaction mixture which, after washing to remove the acid catalyst, contained 20 weight percent of 4,4-BHPF, 64 weight percent of phenol and 16 weight percent water. The reaction mixture was distilled under water jet vacuum (approximated 80 mm Hg) up to a temperature of 160°C to yield a residue, containing approximately 50 weight percent of phenol and 50 weight percent of 4,4-BHPF, that is, a 1:1 phenol:4,4-BHPF mass ratio.

The 1:1 mixture was cooled to 120°C and then poured into 176 g of room temperature methylene chloride, that had been previously saturated with 4,4-BHPF. This results in a clear homogeneous solution at reflux, which was allowed to cool to room temperature. The crystallized mixture was filtered under vacuum at room temperature. The filter cake was displacement washed with 79 g of BHPF-saturated methylene chloride (no stirring of the filter cake during the wash) and then stir-washed with 72 g of hot water (90°C). The resulting white filter cake was dried in air at 60°C to provide a yield of 61 weight percent of the 4,4-BHPF originally detected in the reaction mixture.

E. REMOVAL OF PHENOL-WATER AZEOTROPE

Approximately 380 g of a reaction mixture similar to that of Example 17D were slowly dripped into 4 L of water at a temperature of 84°C at a pressure of 300 mm Hg. This dilution in water was accompanied by the removal of phenol in the form of a water/phenol azeotrope. The water-insoluble materials then precipitate from the liquid phase as a white powder. Approximately 64 g of "crude" BHPF was obtained in this manner. The "crude" BHPF contained all the impurities originally contained in the reaction mixture. The product was filtered, washed with boiling water and dried in air at 60°C to provide a recovery of 96 weight percent of the 4,4-BHPF originally detected in the reaction mixture.

F. CRYSTALLIZATION FROM TRIISOPROPYLBENZENE

A reaction mixture (55.8 g: 63.1 percent by weight, 35 g of phenol; 14 percent by weight of 4,4-BHPF and 23 percent by weight, 12.8 g of water) was charged to a 250-mL round bottom flask, otherwise fitted out as in Example 17A. Triisopropylbenzene (TIPB, 106.6 g) was added to the mixture in the flask, as a result of which the mixture separates into two phases, of which the yellow reaction mixture was the lower.

The mixture was stirred and heated under vacuum, produced by a water jet (ca. 80 mm). After removal of water at 50 to 88°C, the mixture appeared homogeneous. The mixture was stirred and allowed to cool. Solids appear when the temperature reached 70°C. The mixture was allowed to cool to room temperature and filtered on a glass frit under vacuum. The white solids on the frit were washed with TIPB. The filter cake was left overnight under vacuum (water jet) while air was pulled through the filter cake.

Analysis of the resulting mother liquor showed that little of the phenol in the feed was removed as a result of distillation. The filter cake contained 4.2 g of white, nearly free-flowing product (54 percent recovery, 98.8 percent purity by HPLC).

5 G. DISTILLATION TO REMOVE PHENOL; CRYSTALLIZATION FROM METHYLENE CHLORIDE

10 A reaction mixture (98.8 g: 61 percent by weight, 60.3 g of phenol; 19.4 percent by weight, 19.2 g of 4,4-BHPP and 19.6 percent by weight, 19.4 g of water) was charged to an apparatus, described in Example 17F. A collection flask was attached to the distillation arm and connected to a vacuum source (a water jet). The temperature set point was adjusted to 100°C and heating began.

	<u>Temp. (°C)</u>	<u>Observations/Actions</u>
	50-55	boiling and distillation occur
	100	slight bubbling
		set point raised to 120°C
5	105	distillation restarts
	115	insignificant distillation
		set point raised to 140°C
	120	vigorous boiling, little distillation, vapor temperature rising
10	121	vigorous boiling, distillation starting, vapor temperature 115°C
	122	vapor temperature 118°C
		break vacuum and remove sample: 34 g of distillate collected, mixture in pot has phenol:BHPF mass ratio of ca. 2:1
15		reconnect vacuum source and recommence heating
	124	vapor temperature was 119°C, distillation starts
	125	vapor temperature was 119°C
20		break vacuum and sample mixture 13.9 g of distillate collected set point 120°C at atmospheric pressure reconnect vacuum and recommence heating phenol:BHPF 1.6:1 mass ratio in pot
25	129	vapor temperature 121°C
		distillation starts
	131	vapor temperature 123°C
		stop operation, remove sample 42.4 g remain in pot; mixture in pot has phenol:BHPF ratio ca. 1.12:1; 6.7 g of distillate collected
30		

The pot residue at 110°C was added to 172 g of fresh drum-grade methylene chloride in a bottle. The addition was done slowly in order to avoid excessive flashing or boiling of the methylene chloride. The resulting mixture more or less separated into two layers, of which the upper layer was richer in the phenol:BHPF component. The mixture was swirled and became homogeneous. The bottle was sealed and placed in a pan of cold water (approximately 10°C).

	<u>Time</u>	<u>Observations/Actions</u>
	(hr:min.)	
10	0:08	homogeneous yellow solution
	0:18	homogeneous yellow solution
	0:56	yellow solution, possibly small crystals
	1:18	same
	2:00	same
15	2:24	crystallization ongoing, quite a few crystals
	17:48	solid yellow crystalline mass breaks up easily
		filter under vacuum through glass frit to obtain slightly yellow crystals; recover
20		158.8g of yellow mother liquors

The crystallizer bottle was rinsed with 29.7 g of fresh methylene chloride (not all solids dissolve), the resulting mixture being used to displacement wash the filter cake, which improved slightly in color.

The filter cake was slurry washed with 49.4 g of fresh methylene chloride and the resulting slurry was filtered under vacuum. The color of the filter cake was unchanged.

The filter cake was displacement washed with 33 g of cold water, without a change in the color of the cake. The filter cake was slurry-washed with 40 g of boiling water, without a change in the color of the cake.

The cake was dried in air under vacuum for approximately 2 hours, transferred to a watch glass and dried in an oven overnight at 65°C. The cake was slightly yellow.

The mass balance for the process was:

g of BHPF

19.2 in initial mixture

8.1 in mother liquors at end of operation

5 9.1 isolated product

1.7 in wash

0.3 unaccounted for

H. CRYSTALLIZATION FROM DIPHENYLMETHANE

1. A mixture of 28 g of DPM, 17.5 g of phenol, 5.4 g of BHPF
10 (98:2 4,4- to 2,4- isomers, by HPLC) and 12 mg of MPSA was washed with
water. The resulting layers were separated and the water layer was
removed. Phenol was distilled from the organic layer to give a mixture
containing 21.8 g of DPM, 3.8 g of phenol and 5.4 g of BHPF. The mixture
was to be cooled to room temperature to give an off-white precipitate,
15 which was filtered and washed with DPM. The washed cake was dried in an
oven at 60°C to give 6.1 g of material, containing 70 percent by weight of
BHPF and 30 percent by weight of phenol. The mixture was stripped at 140°C
under nitrogen at < 80 mm Hg to give 4.2 g of white solid. The solid, by
HPLC analysis (analytical method 5), contained 99.6 percent by area of the
20 4,4-isomer and 0.04 percent by area of 2,4-isomer.

2. A reaction mixture from 15:1 phenol:fluorenone, containing
34.5 percent by weight of phenol and 10.5 percent by weight of BHPF, was
diluted with 55 percent by weight of DPM. Phenol (80 percent of that
initially present, maximum temperature 105°C, 4.5 mm Hg) was removed by
25 distillation to give, after crystallization from DPM, white BHPF melting
at 221 to 222°C. The recovery of BHPF was 78 percent. The material
contained 99.6 percent of the 4,4-isomer by HPLC.

I. CRYSTALLIZATION FROM NEAT PHENOL

Phenol was distilled from the reaction mixtures to produce mixtures,
30 containing less than 50:50 phenol:BHPF by weight. The resulting materials
can be washed with methylene chloride. The products were inconsistent in
color and contain small crystals, usually of the size of 10 to 70 microns.

J. PRECIPITATION OF BHPF BY ADDITION TO WATER

Addition of reaction mixtures to boiling water or steam removed some
35 phenol as a phenol-water azeotrope. The resulting product retained most
of the extraneous isomers and adducts and comprised very small crystals,

the size of the order of 10 to 20 microns. The maximum purity was 97 to 98 percent.

Analytical data (HPLC) was given in Table VII for Samples, prepared in accordance with the practice of the invention and for commercially-
5 available materials.

K. REMOVAL AND RECOVERY OF PHENOL FROM BHPF REACTION MIXTURE

Excess phenol was removed from a reaction mixture to a 1:1 ratio of phenol:BHPF using a falling film evaporator. This was accomplished at 120° C/120 mm Hg. At this temperature, BHPF solubility in phenol was 45
10 percent.

After removing phenol, the BHPF-phenol mixture was kept at 90°C and stirred prior to addition of methylene chloride or other crystallizing solvent.

BHPF was crystallized at room temperature under a nitrogen pad. A
15 batch crystallizer was cooled to 5 to 10°C for several hours during which BHPF crystallizes. Solid BHPF was separated from the resulting slurry using a batch pressure filter or basket filter. Optionally, a pressure filter can be used. Methylene chloride or other solvent can be recycled to the process.

20 BHPF crystals were dried under vacuum.

BHPF from Sloss (Birmingham, Alabama): The sample evaluated was a dry solid, from lot number 9307-03.

BHPF from Isonova (Austria): The sample evaluated was designated "Isonova 10/93".

25 BHPF from Rutgers-Nease (State College, Pennsylvania): The dry solid was from lot number 9306099.

BHPF from Isovolta (Neudorf, Austria): The sample, used as standard for the comparative studies, was received in 1988 and was designated "Isovolta 1988."

30 Analysis of the results in Table VII shows that 4,4-BHPF, purified by distillative removal of phenol:water azeotrope and extraction with methylene chloride, produces high purity BHPF.

TABLE VII

<u>Sample Source</u>	<u>Lot No.</u>	<u>4,4-BHPF</u>	<u>2,4-BHPF</u>	<u>2:3 BHPF Add.</u>	<u>Other</u>	<u>Total Impur.</u>
Sloss	9307-03	100	~0	0	0	0
Isonova	10/93	100	0	0		0.00
MeCl ₂	Ex. 17D	99.94		0.06		0.06
Water	Ex. 17E	97.59	1.87	0.40	0.14	2.41
ppt'd						
Isovolta	1988	100	0	0		0
Rutgers	93060099	99.28	0.58	0.14		0.72
Nease						
DPM	Ex. 17H	99.6				

EXAMPLE 18

5 CORROSION STUDIES

A. REACTION MIXTURES FOR BHPF PROCESS

Corrosion tests were performed using a representative reaction mixture for the condensation of phenol with fluorenone using various catalysts. The tests were done using metal specimens 3.81 cm in length, 1.59 cm in width, 0.32 cm thick, and having a 0.64 cm hole centered in one end. The specimens were isolated from each other and the mounting rack using polytetrafluoroethylene shoulder washers. The specimens were exposed to both the liquid and vapor phases of each test cell. The contents of the cells were stirred continuously and were maintained at the selected temperature using YSI temperature controllers and GLASCOL™ heating mantles. The tests were run under a nitrogen pad. The chloride content of the test mixtures was <500 ppm. The tests were run at 65°C for 13 days (312 hours). Compositions tested and results are presented in Table VIII.

20 Results in Table VIII demonstrate that the reaction mixtures used were considerably less corrosive than conventionally used reaction mixtures.

TABLE VIII

CORROSION TESTING FOR BHPF REACTION MIXTURES

A. Reactor Mixture: 90.2 percent of Phenol, 8.3 percent of Fluorenone, 1.5 percent of MPSA (by weight)

5	<u>Corrosion Rate (mpy)*</u>			
	<u>Metal</u>	<u>Liquid</u>	<u>Vapor</u>	<u>Remarks</u>
	316L ss**	nil***	< 0.1	uniform corrosion
	904L ss	nil	0.1	uniform corrosion
	2205 ss	nil	< 0.1	uniform corrosion
10	254 SMO ss	nil	nil	uniform corrosion

B. Water Extraction Mixture: 8.0 percent of Phenol, 91 percent of Water and 1.0 percent of MPSA (by weight)

15	<u>Corrosion Rate (mpy)</u>			
	<u>Metal</u>	<u>Liquid</u>	<u>Vapor</u>	<u>Remarks</u>
	316L ss	0.1	0.1	uniform corrosion
	904L ss	< 0.1	< 0.1	uniform corrosion
	2205 ss	< 0.1	< 0.1	uniform corrosion
	254 SMO ss	< 0.1	< 0.1	uniform corrosion

C. Recycle Concentrate: 29.87 percent of Phenol, 69.23 percent of Water and 0.9 percent of MPSA (by weight)

20	<u>Corrosion Rate (mpy)</u>			
	<u>Metal</u>	<u>Liquid</u>	<u>Vapor</u>	<u>Remarks</u>
	316L ss	0.1	0.1	uniform corrosion
	904L ss	< 0.1	< 0.1	uniform corrosion
25	Inconel 625	< 0.1	< 0.1	uniform corrosion
	Hastelloy C-27	0.1	< 0.1	uniform corrosion
	Hastelloy G-30	< 0.1	< 0.1	uniform corrosion

* mpy = mils per year; 1 mpy = 0.00254 cm/yr

30 ** ss = stainless steel

*** nil = < 0.01 mpy

B. REACTION MIXTURES FOR BISPHENOL A PROCESS

A mixture containing 94.35 percent by weight of phenol, 4.15 percent by weight of acetone and 1.50 percent of MPSA was evaluated as in Example 18A.

5 The following results were obtained:

<u>Corrosion Rate</u>			
<u>Metal</u>	<u>Liquid</u>	<u>Vapor</u>	
304L ss	pass	pass	pass =
316L ss	pass	pass	< 0.00254 cm/year
10 904L ss	pass	pass	
2205 ss	pass	pass	
825 Ni	pass	pass	

The corrosion rates in both the liquid and vapor phases was < 0.00254 cm/year. The corrosion was uniform. The rate of corrosion was below that for conventional reaction mixtures for making bisphenol A.

EXAMPLE 19

A. PREPARATION OF BISPHENOL A USING PMBSA

Bisphenol A was prepared from 14:1 phenol:acetone (mole ratio) at 50° C, containing the indicated amounts of solid catalyst. The product distribution was determined by analytical method 2.

The PMBSA catalyst of Example 9B, at a level of 6 percent by weight, gives 75 percent conversion after 5 hours. The product contained 99.0:1.0 of 4,4:2,4-isomers (area percent).

The PMBSA was recovered and reused in a second cycle. The conversion after 4 hours was 60 percent. The product contained 99.1:0.9 of 4,4:2,4-isomers (area percent).

DOWEX™ 50WX4, from The Dow Chemical Company, (35 percent by weight as dry mass), promoted with 25 percent by weight of 2,2-dimethylthiazolidine, was used in a similar experiment. The conversion after 4 hours was 43 percent and the product contained 98.0:2.0 (as area percent) of 4,4:2,4-isomers.

These experiments showed that a polymer-supported catalyst of this invention gave higher conversions and a higher yield of 4,4-isomer than a representative prior art catalyst.

35 B. REACTION USING PMBSA IN A DOWNFLOW CONTINUOUS REACTOR

The reactor comprised a vertical tube. The bottom part of the tube was filled with glass beads, on top of which was provided a bed of PMBSA

catalyst resin. The remainder of the tube was filled with glass beads. The tube was fitted with a pressure gauge, a pressure regulator, heating means external to the catalyst bed and feed means at the bottom of the tubular reactor for introducing the phenol and fluorenone reactants. The feed was prepared in a container, provided with a nitrogen stream and heated externally by a fluid. A valve was intermediate the feed preparation container and a pump for introducing the feed into the bottom of the reactor. A relief valve was placed between the pump and the reactor.

The feed was introduced into the reactor at a predetermined rate and passes upwardly through the lower bed of glass beads, which functioned as a pre-heater, through the catalyst bed and the upper bed of glass beads, whereupon the product was removed from the top part of the reactor for analysis or further processing.

Experiments using 21:1 phenol:fluorenone and PMBSA catalyst gave the following results as a function of flow rate and reaction temperature:

	<u>49°C</u>	<u>69°C</u>
Conversion (%)	80	100
BHPF in phenol (%)	14	16
Productivity (g BHPF/g cat/h)	0.57	0.44
Selectivity (% 4,4-BHPF)	98*	97*
Flow rate (g feed/g cat·h)	4.39	2.71

These experiments showed that lower reaction temperatures favored productivity and selectivity toward 4,4-BHPF, accompanied by decreased conversion.

C. CONVERSION OF ACETONE AS A FUNCTION OF REACTION TEMPERATURE

Phenol-acetone mixtures (6 percent by weight acetone) were converted to bisphenol A, using MPSA as catalyst in batch reactors. The following results were obtained (Table IX):

TABLE IX

Acetone Conversion					
25°C*	35°C*	55°C*	65°C	75°C*	
Time (min)					
0	0	0.10	0.22	0.25	0.26
20			0.40	0.48	0.49
25	0.04	0.42			
40			0.59	0.62	0.67
48			0.65	0.69	0.77
60	0.06	0.56	0.69	0.75	
72					0.82
90	0.09		0.79	0.85	0.89
120	0.13	0.72	0.83	0.89	0.94
180	0.20	0.80		0.95	0.96
240	0.26			0.97	
300				0.98	
360	0.32				0.99

* mixture contained 2.2% by weight of MPSA and 2-3% by weight of water

+ mixture contained 1.3% by weight of MPSA and no added water

10 D. REMOVAL OF MPSA CATALYST USING ION-EXCHANGE RESIN;
PURIFICATION OF CRYSTALLINE BISPHENOL A

Condensation of phenol with acetone (4 percent by weight), containing 2 by weight of water, using 2.5 percent by weight of MPSA, was done at 35°C in plug flow mode, with a 3-hour residence time.

15 Crystallization of bisphenol A occurred in the reactor. The crystals were isolated by filtration and residual acetone in the mother liquors was recycled to the process at 50°C. THE mother liquors were dried at 50°C (20 mm Hg) and the cycle was repeated after addition of make-up feed. About 90 percent of the acetone was converted to bisphenol A per pass.

20 Catalyst was removed from the product by first melting the crystals and washing the resulting oil with water, and then extracting the organic layer with water, which reduces the acid concentration below 100 ppm after three equilibrium stages. The remaining catalyst was removed using an anion exchange bed (<50 ppm, the limit of detection).

Bisphenol A, isolated by a single crystallization step, was of higher purity than products, generally obtained using two crystallizations. Bisphenol A isolated by a single crystallization, contained a maximum of 1200 ppm of 2,4-bisphenol. The process of this invention therefore simplifies the isolation of high purity of bisphenol A, uncontaminated by oily higher condensates.

EXAMPLE 20

SOLID CATALYST PREPARED FROM POLYSTYRENE BY ALKYLATION WITH ALLYL BROMIDE, SULFONATION AND THIOLATION

10 A. Polystyrene (Amberlite® XE 305) was alkylated with allyl bromide in the presence of trifluoromethanesulfonic acid in 1,2-dichloropropane at 50°C, generally in accordance with Tomci et al., "A Novel One-pot Synthesis of Spacer- modified Polymer Supports and Phase-transfer Catalytic Activity of Phosphonium Salts Bound to the Polymer
15 Supports", Reactive Polymers, Volume 3 (1985), pages 341-349, to produce a material having 2-bromo-1-methylethyl chains. This material was sulfonated, generally at the ortho-position with respect to the side chain, by treatment with chlorosulfonic acid. The resulting sulfonyl chloride was converted to a sodium salt by reaction with sodium
20 bicarbonate. The material was converted to a corresponding thiol by reaction with sodium thioacetate and converted to a corresponding acid by acidic hydrolysis. Materials prepared correspond to 28 and 48 percent of alkylmercaptan functionality (XEMSA).

25 B. The thus-prepared polymers (XEMSA) were used at a level of 6 percent by weight for reaction between phenol and fluorenone (20.8:1 mole ratio) at 50°C. Product composition was determined by analytical method 3.

The polymer containing 28 percent of alkylmercaptan functionality gives 75 percent conversion after 5 hours. The product distribution was 96.8:3.2 of 4,4:2,4-isomers (area percent).

30 The product containing 48 percent of alkylmercaptan functionality gives 15 percent conversion after 2 hours. The product distribution was 96.8:3.2 of 4,4:2,4-isomers (area percent).

EXAMPLE 21

IN SITU METHOD FOR PREPARING THE POLYMER-SUPPORTED MERCAPTOSULFONIC ACID CATALYST (PMBSA CLASS):

A. SULTONE ALKYLATION

- 5 To a mixture of 1,4-butanedisulfone (30.0 g, 220.0 mmol, 1.00 equivalent) and poly(vinylbenzylchloride) (PVBC, 33.6 g, approximately 220 mmol, 1.00 equivalent) of chloromethyl groups) was added via a cannula dry tetrahydrofuran (600 mL) under a nitrogen atmosphere. The mixture was stirred at room temperature until a homogeneous solution was obtained.
- 10 The solution was then cooled to -78°C using a dry ice/acetone bath. n-Butyllithium (2.5 molar in hexanes, 88.1 mL, 1.00 equivalent) was added slowly dropwise to the -78°C solution of 1,4-butanedisulfone and poly(vinylbenzylchloride) via an addition funnel over approximately 2.5 hours with vigorous stirring. A white solid begins to precipitate from
- 15 the reaction mixture as the n-butyllithium addition was begun, with precipitation continuing throughout the n-butyllithium addition period. By the end of the addition, a large amount of white solid has formed within the reaction medium.

- The reaction mixture (slurry) was allowed to slowly warm to room
- 20 temperature in the cooling bath (over approximately 3 to 4 hours) and was allowed to stir at room temperature overnight. The white precipitate which has formed in the reaction mixture during the n-butyllithium addition period remains insoluble as the mixture reaches room temperature. The white (insoluble) solid was removed by vacuum filtration. The polymer
- 25 can be washed with water or water can be added to the THF/polymer slurry prior to filtration. Addition of water sometimes results in increasing the time required for filtration. The solid was slurry-washed with THF, then with methanol and finally with methylene chloride (causing some swelling). The solid was dried overnight in a vacuum oven to provide 53.4
- 30 g of a white solid sulfone-functional polymer.

B. THIOLATION

- To the sulfone-functional polymer from above (110.0 g from two combined batches, approximately 0.440 mol of sulfone) was added nitrogen-saturated THF (500 mL). In a separate reactor, a solution of lithium
- 35 thioacetate was prepared by the dropwise addition of thioacetic acid (49.8 g, 0.650 mol) to a slurry of lithium carbonate (24.2 g, 0.330 mol) in water (100 mL, nitrogen saturated). The lithium thioacetate solution

was added slowly via cannula to the polymer/THF slurry at such a rate that the temperature does not rise above 35°C. The polymer swells substantially during the lithium thioacetate addition. After the lithium thioacetate addition was complete, an additional 350 mL of water (nitrogen saturated) was added. The polymer swells to a volume of approximately 1 L. The mixture was heated to 50°C, and was allowed to react overnight. The gel-like polymer was then filtered using a coarse glass-fritted funnel. The polymer was washed with water, then with methanol, then with methylene chloride, and finally with additional water. The polymer slurry sometimes filters very slowly during the filtration process. In this case, the washing steps required approximately two days.

After the washing steps, concentrated hydrochloric acid (300 mL, approximately 37 percent by weight in water) was added to the polymer. The polymer shrinks in volume and the HCl solution was easily removed by filtration. More concentrated HCl (300 mL) was added to the filtered solid, and the mixture was allowed to stand at room temperature over 2 days. The polymer was then washed extensively with dilute HCl solution, followed by extensive water washes. The polymer was then washed with methanol and finally with dichloromethane. Drying overnight in a vacuum oven (60°C/full vacuum) provided the polymer-supported mercaptosulfonic acid. The product was identified as PMBSA-SU.

C. CONVERSION OF CROSSLINKED POLYSTYRENE RESIN TO
MERCAPTOSULFONIC ACID POLYMER

A commercially-available (Fluka Chimika) crosslinked chloromethylated Merrifield® resin (2 percent divinylbenzene, 200 to 400 mesh, approximately 4.3 mmol Cl/g, 51.2 g, 1.0 equivalent) was reacted with 1,4-butanedisulfone (1.05 equivalents) and n-butyllithium (1.0 equivalent) according to the procedure described above to provide a disulfone-functional polymer (70.0 g). Subsequent thiolation of the disulfone polymer in a manner similar to that described above provided the corresponding mercaptosulfonic acid polymer (79.0 g dry mass). This material was identified as PMBSA-MER.

In this reaction sequence, the lithium thioacetate reagent was formed *in situ* by slowly adding solid lithium carbonate to a mixture of the disulfone polymer and thioacetic acid in a 3:2 volume ratio of nitrogen-saturated THF/water.

EXAMPLE 22

PREPARATION OF POLYMER-SUPPORTED MERCAPTOSULFONIC ACID CATALYST (XEMSA CLASS)

A. ALKYLATION OF POLYSTYRENE

5 To Amberlite™ XE-305 (75.0 g, approximately 0.720 mol of styrene repeat units, 1.00 equivalent) was added 600 mL of 1,2-dichloropropane (PDC). The polymer was allowed to swell in the solvent overnight. 5-Bromo-1-pentene (75.3 g, 0.702 equivalent) and PDC (125 mL) were added to an addition funnel. The reactor contents (polymer slurry and 5-bromo-1-pentene solution) were evacuated and back-filled with nitrogen several times. Trifluoromethanesulfonic acid (20.0 g, 0.133 mol, 0.19 equivalent) was added to the polymer/PDC slurry. The slurry solution turned a dark amber color. The polymer slurry was heated to 45 to 50°C, and slow, dropwise addition of the 5-bromo-1-pentene solution was begun. The 5-bromo-1-pentene solution was added slowly over approximately 3 days to the stirred polymer slurry at 50°C. After the 5-bromo-1-pentene addition was complete, the reaction was allowed to stir an additional 1 day at 50°C. The polymer slurry was very dark-colored throughout the addition period.

The polymer slurry (very dark red-brown) was cooled to room temperature and filtered. The beads were washed extensively with dichloromethane (still dark colored beads) and then were washed extensively with water to remove most of the color. The beads were then washed with the following series of solvents: methanol, acetone, dichloromethane, acetone, and, finally, methanol. After drying in a vacuum oven at 60°C overnight, 96.46 g of nearly white bromoalkylated polymer beads were obtained. The mass uptake corresponded to a degree of functionalization (DF) of approximately 0.20.

B. SULFONATION

To the dried bromoalkylated polymer beads prepared above (approximately 0.720 mol of styrene repeat units) was added 650 mL of dichloromethane under a nitrogen atmosphere. The polymer slurry was cooled to 0°C using an ice water bath. Chlorosulfonic acid (258.2 g, 2.22 mol, 3.08 equivalents) was added slowly dropwise to the polymer slurry at 0°C over 2 hours 40 minutes. The polymer beads turn copper-colored during the chlorosulfonic acid addition. After the addition was complete, the reaction mixture was allowed to slowly warm to room temperature within the water bath. The volume of the swollen polymer was approximately 500 to

600 mL within the reactor. After warming to room temperature, the polymer slurry was allowed to stand overnight without stirring. The liquid layer was then removed from the polymer using a small-bore cannula. The beads were then washed several times with dichloromethane. (The liquid layer and dichloromethane washes were slowly and carefully quenched in a separate vessel using ice.) The polymer beads were then carefully transferred to a fritted-glass funnel, and the polymer beads were quenched by slow, careful addition of ice water.

After washing the beads extensively with water, excess solid sodium bicarbonate was slowly added to a suspension of the polymer beads in water. The mixture was allowed to stand overnight at room temperature. The polymer/sodium bicarbonate mixture was then heated to 50°C for 2 hours. The polymer slurry was allowed to stand at room temperature for 6 days. The polymer was light-colored and more highly swollen at this point. The slurry was heated to 50°C and allowed to react overnight, giving a pH 4 solution of even more swollen polymer (approximately 600 to 700 mL volume). Addition of a small amount of sodium bicarbonate gives a pH 7 solution.

C. THIOLATION

To the aqueous polymer bead slurry from above was added sodium bicarbonate (60.5 g, 0.720 mol). The mixture was evacuated and back-filled with nitrogen three times. Thiolacetic acid (41.1 g, 0.540 mol) was added slowly dropwise over 1 hours 10 minutes to the polymer slurry at room temperature. The mixture was slowly warmed to 80°C over several hours and allowed to react at 80°C for 3 days. After cooling to 40°C, the supernatant solution was removed using a small-bore cannula. The polymer was washed several times with water, giving slightly off-white colored polymer beads. Concentrated hydrochloric acid (250 mL) was added to the polymer and the slurry was heated to 50°C for 3 hours. After cooling to room temperature, the hydrochloric acid solution was removed using a small-bore cannula. The polymer beads were then washed several times with diluted hydrochloric acid and the beads were transferred to a fritted-glass funnel. The beads were again washed repeatedly with diluted hydrochloric acid followed by extensive washings with water, giving slightly off-white water-swollen beads. (The water-swollen volume of the polymer beads was approximately 900 mL.) The beads were washed with methanol (methanol-swollen volume approximately 600 mL) and finally with

dichloromethane. After drying in a vacuum oven at 60°C overnight, the dark-colored beads had a dry volume of approximately 200 mL. This product was identified as XEMSA-5C.

D. PREPARATION OF CATALYST FROM POLYSTYRENE AND 11-BROMO-1-UNDECENE (XEMSA-11C)

Catalyst was prepared as above, starting with macroporous polystyrene (Amberlite™ XE-305) and 11-bromo-1-undecene.

EXAMPLE 23

EVALUATION OF POLYMERIC MERCAPTOSULFONIC ACID CATALYSTS

A. EVALUATION OF THE MERCAPTOSULFONIC ACID POLYMER (XEMSA-5C) IN THE REACTION OF PHENOL WITH FLUORENONE

To a 4-dram vial equipped with a stirring bar was added 4.32 g of a 20.8:1 molar ratio mixture of phenol to fluorenone and 0.26 g (6 percent by weight of the reactant solution) of the mercaptosulfonic acid polymer (XEMSA-5C) prepared as described in Example 22A-C. The reaction mixture consists of a homogeneous liquid phase plus a separate heterogeneous polymer catalyst phase. The mixture was heated to 50°C for 5 hours. The reaction was monitored throughout the reaction period by collecting samples and analyzing by HPLC. The 9-fluorenone was found to be 36 percent consumed within 2 hours and 76 percent consumed within 5 hours. HPLC analysis (analytical method 3) gives the following relative area percent analysis for the products after 5 hours of reaction (76 percent conversion): 9,9-bis-(4-hydroxyphenyl)fluorene (97.45 area percent) : 9-(2-hydroxyphenyl)-9-(4-hydroxyphenyl)fluorene (2.17 area percent) : adduct containing two fluorene units and three phenolic units (0.39 area percent).

B. EVALUATION OF THE MERCAPTOSULFONIC ACID POLYMER (XEMSA) IN THE REACTION OF PHENOL WITH FLUORENONE

To a 4-dram vial equipped with a stirring bar was added 4.32 g of a 20.8:1 molar ratio mixture of phenol to fluorenone and 0.26 g (6 percent by weight of the reactant solution) of the mercaptosulfonic acid polymer (XEMSA, degree of functionalization approximately 0.28 from bromoalkylation step) prepared as described in Example 20. The reaction mixture consisted of a homogeneous liquid phase plus a separate heterogeneous polymer catalyst phase. The mixture was heated to 50°C for 5 hours. The reaction was monitored throughout the reaction period by collecting samples and analyzing by HPLC. The 9-fluorenone was found to

be 44 percent consumed within 2 hours and 75 percent consumed within 5 hours. HPLC analysis (analytical method 3) gives the following relative area percent analysis for the products after 5 hours of reaction (75 percent conversion): 9,9-bis-(4-hydroxyphenyl)fluorene (96.10 area percent): 9-(2-hydroxyphenyl)-9-(4-hydroxyphenyl)fluorene (3.52 area percent): adduct containing two fluorene units and three phenolic units (0.38 area percent).

C. EVALUATION OF MERCAPTOSULFONIC ACID POLYMER (PMBSA-MER) IN THE REACTION OF PHENOL WITH FLUORENONE

To a 4-dram vial equipped with a stirring bar was added 4.32 g of a 20.8:1 molar ratio of phenol:fluorenone and 0.26 g (6 percent by weight of the reaction solution) of PMBSA-MER of Example 21C. The reaction mixture consists of a homogeneous liquid phase plus a separate heterogeneous polymeric catalyst phase. The mixture was heated at 50°C for 2 hours. The reaction was monitored by collecting samples, which were analyzed by HPLC. The 9-fluorenone was 99.5 percent consumed within 2 hours. The product after 2 hours contained 96.83 area percent of 9,9-bis-(4-hydroxyphenyl)fluorene, 2.44 area percent of 9-(2-hydroxyphenyl)-9-(4-hydroxyphenyl)fluorene and 0.72 area percent of an adduct containing two fluorene units and three phenolic units by HPLC (analytical method 3).

D. EVALUATION OF MERCAPTOSULFONIC ACID POLYMER (PMBSA-SU) FOR THE REACTION OF PHENOL WITH FLUORENONE

To a 4-dram vial equipped with a stirring bar was added 4.32 g of a 20.8:1 molar ratio mixture of phenol:fluorenone and 0.26 g (6 percent by weight of the reactant solution) of the polymer of Example 21B (PMBSA-SU). The reaction mixture consisted of a homogeneous liquid phase plus a separate heterogeneous polymer catalyst phase. The mixture was heated to 50°C for 5 hours. The progress of the reaction was followed by HPLC. At the end of 2 hours, 67 percent of the fluorenone was consumed, and 85 percent at the end of 5 hours. At the end of 5 hours, the reaction mixture contained 97.09 area percent of 9,9-bis-(4-hydroxyphenyl)fluorene, 2.25 area percent of 9-(2-hydroxyphenyl)-9-(4-hydroxyphenyl)fluorene and 0.66 area percent of an adduct containing two fluorene units and three phenolic units by HPLC analysis.

Results for the evaluation of various polymer mercaptosulfonic acids for condensing phenol with fluorenone were given in Table X.

TABLE X
CONVERSION OF FLUORENONE (%) USING 6% BY WEIGHT OF POLYMERIC CATALYSTS AT
50°C

Resin	Reaction time (h)					
	0	2	4	5	7	18
PMBSA-MER	0	99.5				
PMBSA-SU (PVBC)	0	67		85		
PMBSA (PVBC)	0	66				
XEMSA-5C	0	36		76		
(Amberlyte™ XE-305)						
XEMSA	0	49		75	82	
(Amberlyte™ XE-305)						
DOWEX* 50 (DMT promoted)	0		17			73

*Trademark of The Dow Chemical Company.

5 *Amberlyte™ Trademark of Rohm and Haas

EXAMPLE 24

EVALUATION OF THE MERCAPTOSULFONIC ACID POLYMERS IN THE REACTION OF PHENOL WITH ACETONE

10 To a 4-dram vial equipped with a stirring bar was added 4.33 g of a 14:1 molar ratio mixture of phenol to acetone and 0.26 g (6 percent by weight of the reactant solution) of the appropriate mercaptosulfonic acid polymer. The reaction mixture typically consists of a homogeneous liquid phase plus a separate heterogeneous polymer catalyst phase. The mixture

15 was heated and allowed to react at 50°C. The reaction was monitored throughout the reaction period by collecting samples and analyzing by HPLC. HPLC analysis (analytical method 3) shows the following acetone percent conversion data (based upon the quantity of bisphenol A produced) for the different catalysts are given in Table XI:

TABLE XI
% ACETONE CONVERSION
(BASED UPON BISPHENOL A PRODUCED)

5

Resin	Reaction time (h)					
	0.0	1.0	2.25	2.5	4.0	5.0
DOWEX* 50WX4, 25% DMT promoted	0		18		44	
PMBSA (from uncrosslinked PVBC)	0		35		60	75
XEMSA-5C (DF = 0.20)	0		38			82
XEMSA (DF = 0.28)	0		23			32
PMBSA-SU	0	2		9		
PMBSA-MER (2% cross-linked, 200-400 mesh)	0	66		88		

*Trademark of The Dow Chemical Company

DMT was 2,2-dimethylthiazolidine

EXAMPLE 25

- 10 A. PREPARATION OF BHPF; METHYLENE CHLORIDE AZEOTROPE TO REMOVE WATER; PRECIPITATION FROM METHYLENE CHLORIDE; 5.75:1 MOLAR RATIO OF PHENOL TO 9-FLUORENONE; COPRECIPITATION WITH TETRACHLOROETHYLENE

To a reactor (isothermal stirred batch reactor; reactor design 4) was charged 75.0 g (0.80 mole) of phenol and 24.98 g (0.1386 mole) of 9-fluorenone. The mixture was heated to 40°C and catalyst (0.973 g, 0.0062 mole, 3-mercaptopropanesulfonic acid) was charged to the reactor. Heating was continued. The course of the reaction was followed by HPLC (analytical method 3). At 30 percent conversion, methylene chloride (15 g) was added to the reaction mixture so as to keep the mixture stirred, and to use a water/methylene chloride azeotrope (180 mm Hg, T = 37°C) to remove water of reaction. The reaction mixture was cooled at the end of the reaction (nearly complete fluorenone consumption, >99 percent of theoretical water) to increase the amount of crystalline precipitate. The progress of the run is given in Table XII.

25 The reaction mixture (about 97 percent selectivity to 4,4-BHPF, little unreacted fluorenone) was split into two parts. The first fraction (53.3 g) was filtered. The filter cake was washed with methylene chloride (49 g) and then with hot water (55 g). The recovery was 6.4 g (first crop)

and 0.6 g (second crop) of white crystals, corresponding to 99 percent purity 4,4-BHPF (33 percent recovery).

To the remainder of the mixture (70.3 g) was added 61 g of tetrachloroethylene. The crystals were removed by filtration and the
 5 filter cake was washed with 50 g of tetrachloroethylene and then with 115 g of hot water. The recovered product weighed 11.5 g (43 percent recovery, 99 percent as 4,4-BHPF, white solid).

These results showed that use of tetrachloroethylene, in combination with methylene chloride, gives higher recovery of 99 percent pure 4,4-
 10 BHPF).

TABLE XII

<u>Time</u> h:min	<u>Temp.</u> °C	<u>mm. Hg</u>	<u>Observations, Actions</u>
0:0	37	760	Add MPSA; turns orange, then dark green brown
0:20	36	760	Color light brownish
0:40	36	760	Sample taken
1:15	36	760	Seed crystal added
2:10	36	760	Sample taken
2:28	36	760	Methylene chloride (15 g) and seed crystal added; no crystallization; temp. raised to 45°C
2:30	37	-180	Sample taken; seed crystal not dissolving
3:10	45	-180	Heater set at 40°C
3:30	40	-180	Seed crystals added
3:50	40	-180	Mixture hazy
4:30	40	-180	Mixture hazy
5:10	40	-180	Sample taken
6:43	40	760	Vacuum turned off, stirrer speed increased
9:30	40	760	Sample taken; methylene chloride (about 20 g) added to mixture; stirrer speed increased; heater turned off

B. USE OF METHYLENE CHLORIDE AZEOTROPE TO ACCELERATE REACTION;
5.75:1 MOLAR RATIO OF PHENOL TO 9-FLUORENONE

To a reactor (reactor design 5) was charged, 75.0 g (0.80 mole) of phenol, 24.98 g (0.1386 mole) of 9-fluorenone and 15.0 g of methylene chloride. The mixture was heated to 40°C. Catalyst (3-mercaptopropanesulfonic acid, 0.757 g, 0.0049 mole) was charged to the reactor and the mixture was stirred. The reaction was followed by HPLC (analytical method 3).

At the end of the reaction, methylene chloride was added to produce a mixture of 30:30:about 30 percent by weight of methylene chloride:BHPF:phenol and the mixture was heated to dissolve the crystalline material. Additional methylene chloride was added to the solution and the solution was cooled to promote crystallization.

The progress of the reaction was shown in Table XIII.

At the end of the reaction, half of the resulting mixture was filtered and the filter cake was washed with 64 g of methylene chloride. The first crop of BHPF weighs 7.0 g (dried overnight at 40°C) and was white with very little pink coloration. A second crop of crystals was collected and washed with 28 g of methylene chloride. Weight, 4.1 g (dried overnight at 40°C, slightly pink), 99 percent purity after a further washing with water.

The remainder of the reaction mixture was filtered and the filter cake was washed with methylene chloride and hot water and dried overnight at 40°C.

C. The recovery was 14 g (51 percent overall recovery), 99 percent purity by HPLC.

TABLE XIII

<u>Time</u> h:min	<u>Temp.</u> °C	<u>mm. Hg</u>	<u>Observations, Actions</u>
0:0	45	760	Add MP5A, turns dark
0:09	45	760	Add 20 g of methylene chloride; color was dark brownish
0:30	45	760	Lighter brown; reduce pressure to about 180 mm
1:00	45	-180	Seed crystal added; no crystallization observed
2:00	45	-180	Seed crystal added; no crystallization observed
3:00	45	-180	Sample taken; seed crystal added; crystal not dissolving
3:45	45->	-180	Heater set at 40°C; crystals forming
4:00	40	-180	More crystals forming
6:30	40		Sample taken; solid crystalline mass; stirring ineffective; yellowish color; vacuum turned off
19:00	40	760	Sample taken; about 50 to 70% of BHPF crystallized; 33% by weight of methylene chloride added; temperature increased to 58°C
about 20:30	58	760	Temperature lowered to <40°C; methylene chloride added to 80% make up by weight of mixture
	24	760	Cooled to room temperature

C. REACTION USING METHYLENE CHLORIDE AS SOLVENT: 3.5:1 MOLAR RATIO OF PHENOL TO FLUORENONE

Phenol (30.0 g, 0.32 mole), 9-fluorenone (16.41 g, 0.0911 mole) and 15.0 g of methylene chloride were charged to a reactor (reactor design 4). The mixture was stirred and heated at 40°C and 1.122 g (0.0072 mole) of MPSA was added over about 1 minute. Heating was continued at 41°C for the duration of the reaction. The following observations were made during the run:

	<u>Time (h)</u>	<u>Temp. (°C)</u>	<u>Observations, Actions</u>
10	0	41	MPSA added; turns orange to brown to dark brown within 30 sec
	0.18	41	purple color
	0.5	41	sample taken
	1.5	41	sample taken
15	1.67	41	orange mixture seeded with crystals
	3	41	sample taken; heater off; left overnight
	4	41	heater off
	6	room	sample taken; about 80% conversion; more 2:3 adduct than 2,4 adduct

The crystalline solid was removed by filtration and the filter cake was washed with methylene chloride. A second crop of crystals was recovered from the mother liquors. The yield was 0.86 g (first crop), 8.66 g (second crop), 3.5 g (third crop), overall 13 g (41 percent), >99 percent purity by HPLC (method 3).

C. PHENOL:FLUORENONE MOLAR RATIO OF 15:1; MPSA CATALYST; PHENOL REMOVED BY DISTILLATION; CRYSTALLIZED FROM METHYLENE CHLORIDE

To a mixture of phenol and fluorenone (15:1 molar ratio), heated to 65°C, was added 0.0498 equivalent of 3-mercaptopropanesulfonic acid (with respect to fluorenone). The resulting mixture was heated at 65°C for 2 hours, after which the reaction mixture was washed with water (14 times the volume of the mixture) to remove MPSA. The washed reaction mixture was distilled to a phenol:BHPF weight ratio of 1:1 and cooled to bring about crystallization of BHPF. Crystalline material was removed by filtration, washed with methylene chloride, washed with water and dried to give BHPF (99.8 percent by weight of 4,4-isomer).

EXAMPLE 26

CONDENSATION OF PHENOL AND ACETONE TO PRODUCE 2,2-BIS-(4-HYDROXYPHENYL)PROPANE

- 5 A. FEED CONTAINING 6 percent BY WEIGHT OF ACETONE, PLUS WATER,
SOLUBLE CATALYST; BATCH REACTION

The reaction was carried out in a 2-L jacketed baffled resin pot, equipped with a condenser and nitrogen purge. Isothermal temperature control was provided by a fluid material, circulated through the reactor jacket. Stirring was provided by a Lightnin Labmaster® TS2510 stirrer,
10 equipped with an A-310 impeller.

To the reactor was charged 1200 g of feed, containing 90.0 percent by weight of phenol, 6.0 percent by weight of acetone, 1.8 percent by weight of water and 2.2 percent by weight of MPSA. The mixture was heated at 35° C. At the end of 2 hours heating, crystallization occurs in the reaction
15 mixture. The reaction was continued 1 hour more, at the end of which 80 percent of the acetone was reacted (HPLC). The reaction mixture was removed from the reactor and filtered. The weight of recovered crystals was 17 percent, consisting of a 1:1 adduct of BPA:phenol (molar ratio). The crystalline adduct was washed with phenol. The washed adduct
20 contained 57.7 percent by weight of 4,4-bisphenol, 160 ppm of 2,4-bisphenol, 200 ppm of trisphenol, 2270 ppm of other trace bisphenolic impurities and 1170 ppm of MPSA, the balance being phenol. The mother liquor contained 8.44 percent by weight of 4,4-bisphenol, 0.26 percent by weight of 2,4-bisphenol, 0.13 percent by weight of trisphenol 0.62 percent
25 by weight of other bisphenolic impurities, 0.81 percent by weight of acetone, 2.95 percent by weight of water and 2.78 percent by weight of MPSA, the balance being phenol.

B. REACTION USING RECYCLED MOTHER LIQUORS

The mother liquor from (A) was charged to a rotary evaporator with
30 make-up phenol (181 g). The evaporator was heated at 50°C for 30 minutes, at the end of which the conversion of acetone was 90 percent. Pressure was reduced to 10 mm Hg absolute for 30 minutes, at the end of which the mixture contained 1.4 percent by weight of water. The acetone content was below the detection limit.

35 The dried mother liquor was returned to the reactor, along with make-up phenol, acetone, water and MPSA to give a mixture containing 92.0 percent by weight of phenol, 4.0 percent by weight of acetone, 1.8 percent by

weight of water and 2.2 percent by weight of MPSA. The total mass corresponds to (A) minus the weight of samples removed. The mixture was stirred and heated at 35°C for 3 hours. Crystallization of BPA was observed after the initial 30 minutes of heating. At the end of 3 hours heating, acetone conversion was 80 percent. The reaction mixture was processed as in (A). Recycling of the mother liquors was repeated for 12 cycles. Results are given in Tables XIV and XV.

These experiments demonstrate that catalyst and unreacted materials can be recovered and recycled without adversely affecting the process and that results for successive runs were generally consistent and predictable.

C. REACTION USING 10 percent BY WEIGHT OF ACETONE IN THE FEED WITH 3 percent BY WEIGHT OF WATER

An experiment was done as in (A), using 1200 g of feed, containing 85.5 percent by weight of phenol, 10.0 percent by weight of acetone, 3.0 percent by weight of water and 2.2 percent by weight of MPSA. The reaction was done at 25°C. Crystalline BPA was visible after 13 hours at this temperature. At the end of 24 hours, the conversion of acetone was 40 percent.

Crystalline product, removed from the reaction mixture by filtration, constitutes 15 percent of the mixture. The crystals, a 1:1 adduct of BPA:phenol, were washed with phenol. The washed crystals contain 51.8 percent by weight of the 4,4-isomer, 60 ppm of 2,4-isomer, <20 ppm of trisphenol, 690 ppm of other trace bisphenols and 840 ppm of MPSA, the remainder being phenol. The mother liquors contained 6.73 percent by weight of 4,4-isomer, 0.15 percent by weight of 2,4-isomer, 0.08 percent by weight of trisphenol, 0.76 percent by weight of other bisphenols, 5.71 percent by weight of acetone, 4.97 percent by weight of water and 2.66 percent by weight of MPSA, the remainder being phenol.

TABLE XIV

COMPOSITION OF WASHED BISPHENOL A CRYSTALS

Cycle No.	Crystal %	4,4- isomer wt. %	2,4- isomer ppm	Tris- phenol ppm	Other bis- phenol ppm	MPSA ppm
1	17	57.7	160	200	2270	1170
2	22	60.4	420	n/d*	1730	1940
3	17	59.7	460	270	2380	670
4	18	60.7	560	260	2270	1440
5	26	57.9	870	410	1840	1070
6	18	59.3	790	330	2050	2110
7	18	59.3	790	390	2150	740
8	19	59.6	770	280	2100	750
9	22	59.4	840	390	2000	860
10	31	62.5	920	380	2210	1060
11	21	64.0	710	350	2020	1410
12	23	63.0	770	280	1900	1500
Avg.	22±5	61±2	800±70	350±50	2100	1100
Cycles 7-12					±100	±300

* n/d = not detected

TABLE XV

Cycle No.	MOTHER LIQUOR COMPOSITIONS						MPSA wt %
	4,4-Isomer wt %	2,4-Isomer wt %	Tris-phenol wt %	Other bisphen-ol-ics wt %	Acetone wt %	Water wt %	
1	8.44	0.26	0.13	0.62	0.81	2.95	2.78
2	7.53	0.48	0.23	0.47	0.63	2.94	2.89
3	8.30	0.55	0.24	0.38	0.79	2.94	2.75
4	8.42	0.66	0.29	0.41	0.70	2.63	2.87
5	8.92	0.78	0.43	0.42	0.86	2.81	2.73
6	8.22	0.86	0.44	0.46	0.73	3.06	2.84
7	7.92	0.87	0.42	0.46	0.66	3.09	2.83
8	8.03	0.91	0.44	0.49	0.58	3.07	2.84
9	8.09	0.84	0.36	0.45	0.72	3.02	2.44
10	6.86	1.03	0.51	0.46	0.25	2.64	2.92
11	7.59	0.78	0.33	0.44	0.51	3.01	2.69
12	7.87	0.84	0.39	0.42	0.27	3.17	3.14
Avg.	7.7±0.5	0.88	0.41	0.45	0.5±0.2	3.0±0.2	2.8
Cycles 7-12		±0.09	±0.06	±0.02			±0.2

Example 27

- 5 Preparation of a Representative [(Mercaptoalkyl)(Sulfo)Phenylalkyl] Sulfonated Polystyrene Catalyst (Designated DPMSA-MER3C)

A. Alkylation

- A 15.00 g sample of 200 to 400 mesh chloromethylated polystyrene/2 percent divinylbenzene copolymer beaded (approximately 4.3 mmol Cl/g resin, approximately 64.5 mmole Cl) known in the art as a Merrifield® resin (available from Fluka Chemie AG) was added to a round bottom glass flask (reactor) under a pad of plant nitrogen with a sodium hydroxide scrubber attached (to trap evolved HCl). (3-Bromopropyl)benzene (102.7 g, 78.4 mL, 8.0 equivalents) was added to the dry resin beads. Dried (over 3 Angstrom molecular sieves) nitrobenzene (50 mL) was added, and the beads were slowly stirred at room temperature to allow for swelling of the beads. The reactor was cooled to 0°C in an ice water bath. A 20 mL sample of 1.0 M aluminum chloride in nitrobenzene available from Aldrich Chemical Co. was slowly added via syringe to the cold polymer slurry with rapid stirring over approximately 10 minutes. The mixture turns dark red as soon as the aluminum chloride solution was added and exotherms to approximately 4°C within the first 15 minutes of reaction with HCl being

evolved from the solution. After the addition of the AlCl_3 /nitrobenzene solution was complete, the mixture was slowly stirred at 0°C for 2 to 3 hours, then was removed to room temperature and slowly stirred overnight. The mixture was slowly poured onto ice to quench the aluminum chloride.

5 Then the beads were separated using a glass-fritted funnel with vacuum filtration. The beads were sequentially washed with water, acetone, dichloromethane, methanol, dilute aqueous hydrochloric acid, water and methanol, then were dried overnight in a vacuum oven at 70°C (dry mass 23.52 g).

10 B. Sulfonation

The polymer beads from Example 27A (23.30 g, estimated 161.3 mmole of phenyl groups) were added to a glass reactor with addition funnel and NaOH scrubber attached. Dichloromethane (100 mL) was added to the flask and the beads were allowed to swell (rapid swelling was observed). The
15 slurry was cooled to 0°C in an ice water bath. Chlorosulfonic acid (37.6 g, 21.4 mL, 320 mmole, approximately 2.0 equivalents per equivalent phenyl groups) was slowly added dropwise over approximately 2 hours to the polymer slurry at 0°C . The mixture was allowed to slowly warm to room temperature overnight in the water bath. The mixture was slowly poured
20 onto ice to quench the excess chlorosulfonic acid, then the beads were separated using a glass-fritted funnel with vacuum filtration. The beads were then washed extensively with water. Water was added to make a slurry, then solid sodium bicarbonate was slowly added in small portions over approximately 2 hours until no more bubbling was observed (all active
25 acid sites neutralized). The mixture was allowed to stand 3 days in the aqueous sodium bicarbonate solution (some additional bead swelling was observed over this time period). The beads were washed with water and transferred to a glass reactor with 100 mL of water. The beads were then heated to 70 - 80°C over 2 hours to ensure hydrolysis of any residual
30 sulfonyl chloride groups.

C. Thiolation

The aqueous polymer slurry from Example 27B was cooled to room temperature. Sodium bicarbonate was slowly added until the slurry was neutral (no bubbling observed), then additional sodium bicarbonate (27.1
35 g, 323 mmol) was added to the aqueous bead slurry. Thiolacetic acid (24.6 g, 23.1 mL, 323 mmol) was added to an addition funnel. The reactor was evacuated and refilled with nitrogen several times to minimize the air

content. The thiolacetic acid was slowly added over approximately 15 to 20 minutes to the aqueous bead slurry with rapid stirring. The addition rate was adjusted to control the effervescent evolution of carbon dioxide which was formed in the neutralization process. After the thiolacetic acid addition was complete, the mixture was heated to 70°C and was allowed to react overnight with minimal stirring. The mixture was then cooled to room temperature and the beads were collected by filtration using a fritted-glass funnel. The beads were washed extensively with water, then with dichloromethane, and then washed again with water. The beads were transferred back to the glass reactor, then concentrated (12 molar) hydrochloric acid (100 mL) was added. The mixture was heated with mild stirring to 50°C for 4 to 5 hours, then was cooled to room temperature. Deionized water (100 mL) was added and the beads were again collected by filtration using a fritted-glass funnel. The beads were washed with water, then were washed extensively (approximately 500 mL) with dilute (approximately 3 molar) aqueous hydrochloric acid. The beads were then washed again with deionized water and finally were washed with methanol to displace the water and shrink the polymer beads. The beads were dried overnight in a vacuum oven at 70 °C (dry mass 34.17 g). The final polymer catalyst was designated as DPMSA-MER3C

D. Preparation of Three-Carbon DPMSA Polymer From Merrifield® Resin Beads

Another mercaptosulfonic acid polymer was prepared using the procedure of steps A to C of Example 27, except using a chloromethylated polystyrene resin (2 percent divinylbenzene, 200 to 400 mesh, approximately 4.3 mmol Cl/g resin), a Merrifield® resin commercially available from Fluka Chemie AG as the polymeric support and (3-bromopropyl)benzene in the alkylation step of the reaction. The resulting polymer was identified as DPMSA-MER3C.

E. Preparation of Three-Carbon DPMSA Polymer From Chloromethylated Gel-Resin Beads

Another mercaptosulfonic acid polymer was prepared using the procedure of steps A to C of Example 27, except using a chloromethylated 1.5 percent crosslinked polystyrene gel-resin (-30+70 mesh, approximately 4.3 mmol Cl/g resin) as the polymeric support and (3-bromopropyl) benzene in the alkylation step of the reaction. This polymer was identified as DPMSA-1.5X3C.

F. Preparation of Two-Carbon DPMSA Polymer From Chloromethylated Gel-Resin Beads

Another mercaptosulfonic acid polymer was prepared using the procedure of steps A to C of Example 27, except using a chloromethylated 1.5 percent crosslinked polystyrene gel-resin (~30+70 mesh, approximately 4.3 mmol Cl/g resin) as the polymeric support and (2-bromoethyl) benzene in the alkylation step of the reaction. This polymer was identified as DPMSA-1.5X2C.

G. Preparation of three Carbon DPMSA from 6 percent Crosslinked Macroporous Resin

Another mercaptosulfonic acid polymer was using the procedure of steps A to C of Example 27, except using a chloromethylated 6 percent crosslinked macroporous polystyrene resin (approximately 30 to 70 mesh, approximately 4.3 mmol Cl/g resin) as the polymeric support and (3-bromopropyl)benzene in the alkylation step of the reaction. This polymer was identified as DPMSA-6/42-3C.

H. Preparation of three Carbon DPMSA from 6.5 percent Crosslinked Gel Resin

Another mercaptosulfonic acid polymer was using the procedure of steps A to C of Example 27, except using a chloromethylated 6.5 percent crosslinked uniform particle size polystyrene gel-resin (380 micron, approximately 4.3 mmol Cl/g resin) as the polymeric support and (3-bromopropyl)benzene in the alkylation step of the reaction. This polymer was identified as DPMSA-6.5X3C.

EXAMPLE 28

EVALUATION OF CATALYSTS IN CONTINUOUS PROCESSES

A fixed bed downflow reactor, having a volume of 10-mL, was constructed from a vertical tube, filled with catalyst. External to the catalyst bed was a preheater area, packed with glass wool. Ancillary equipment includes a pressure regulator, relief valve, pump and heater for the feed. The feed was heated by heating fluid, circulated through the feed pot, and was kept under a nitrogen pad.

The feed was phenol (99.9 percent) and fluorenone (about 99 percent) in a 21:1 molar ratio.

The heating fluid, heating tape and reactor were turned on. The selected catalyst was slurried in phenol at about 45°C. Catalyst-phenol mixture was pigetted into the reactor, at the bottom of which a plug of

glass wool/glass beads was placed to prevent catalyst from leaving the reactor. The phenol:fluorenone was added to the feed pot at 55°C. The pressure was adjusted to about 0.34 bars.

Phenol:fluorenone feed was introduced into the reactor and the
5 composition of the effluent from the reactor was followed by HPLC.

The following results were obtained:

Table XVI

PMBSA-Mer catalyst (Example 9C) at 50°C:

5	productivity	1.4 g BHPF/g cat h	
	conversion	time (h)	% fluorenone conversion
		0.33	99.7
		28	100.0
		53	100.0
10		69	99.7
		89	99.9
		113	100.0
		137	99.8
		144	99.6
15		162	99.6

selectivity 98% 4,4-BHPF

PMBSA-XEBr (Example 9D) at 69°C:

20	productivity	0.6 g BHPF/g cat h	
	conversion	time (h)	% fluorenone conversion
		2	99.8
		15	100.0
		39	100.0
25		63	98.9
		79	99.0
		103	95.5
		127	87.1
		164	83.4

selectivity 98% 4,4-BHPF

PMBSA-XECl (Example 9E) at 56°C:

	productivity	1.48 g BHPF/g cat h
	conversion	time (h) % fluorenone conversion
5	2	99.2
	27	99.1
	63	99.3
	87	98.7
	111	98.9
10	135	98.6
	159	98.3
	164	98.0

selectivity 98% 4,4-BHPF

XEMSA-11C (Example 22D) at 60°C:

15	conversion	time (h)	% fluorenone conversion
	1		99.2
	17		94.4
	41		92.2
	65		91.0

20 DPMSA-MER3C (Example 27D) at 50°C:

selectivity 98% p,p-BHPF

productivity 4 lb BHPF/ 1b catalyst/hour = 4 kg/kg/h

	conversion	time (h)	% fluorenone conversion
	20		99.9
25	24		99.9
	39		99.9
	48		100.0
	66.5		100.0
	75.5		98.9
30	99.5		99.1
	103		98.6
	104		98.7

XEMSA-5C (Example 22) at 55°C:

selectivity 98% p,p-BHPF

productivity 0.43 LB BHPF/LB catalyst/hour = 0.43 kg/kg/h

	conversion	time (h)	percent fluorenone conversion
5		4	99.7
		22	100.0
		46	100.0
		70	100.0
		77	99.7
10		94	99.7
		118	99.7
		142	99.5
		144	99.4
		168	99.3
15		192	99.0
		216	99.0
		240	98.6
		264	98.6

20 DPMSA-XE3C (Example 27A-C) at 56°C:

selectivity 98 percent 4,4-BHPF

	conversion	time (h)	% fluorenone conversion
		30	98.0
		48	95.1
25		72	94.7
		96	92.3
		123	87.3
		144	86.1
		170	83.8
30		240	77.1

These results show that PMBSA, XEMSA, and DPMSA catalysts of the invention can exhibit stability over time, thus, have very useful lifetimes.

EXAMPLE 29

CONTINUOUS PROCESS FOR MAKING BHPF USING MERCAPTOPROPANESULFONIC ACID CATALYST

5 The reactor comprises a three-staged continuous reactor (isothermal perfectly stirred type). The reaction was run at 46°C at a 21:1 molar ratio of phenol:fluorenone (98 percent, Aldrich), the amount of MPSA being 0.05 to 0.07 equivalent of MPSA:mole of fluorenone. The composition of the products was followed by HPLC.

10 The reaction was continued for 228 hours, at the end of which fluorenone conversion was 99.95 percent (reactor 2) or 99.9 percent (reactor 1) and selectivity to 4,4-BHPF was 98.32 percent (reactor 2) or 95.2 percent (reactor 1).

EXAMPLE 30

15 EVALUATION OF CATALYST OF EXAMPLE 22D (KEMSA-5C) IN CONTINUOUS PROCESS FOR MAKING BISPHENOL A

The reactor comprises a vertical upflow column of stainless steel tubing, packed with resin atop a screen and glass beads. The column was heated by a water jacket. The progress of the reaction was followed as above by HPLC.

20 The following results were obtained:

Table XVII

Test		25% promoted *DOWEX™ 50Wx4	XEMSA-5C Example 22D
Acid capacity			
dry	meq/g	4.0	3.5
wet	meq/mL	0.84	1.17
Swell test			
phenol/water vol.		0.55	0.72
Reaction tests			
30 min res. time			
4% acetone, 65°C			
4,4	% by wt	12.7	14.0
conversion		0.83	>0.95
productivity		8.2	9.0 ± 0.2
2,4/4,4		0.28	0.024 ± 0.001
6% acetone, 65°C			
4,4	% by wt	-15	19.1 ± 0.6
conversion		-0.7	0.92
productivity		-10	12.2 ± 0.4
2,4/4,4		-0.27	0.025 ± 0.003
4% acetone, 55°C			
4,4		10.7	13.0 ± 0.1
conversion		0.67	0.92 ± 0.01
productivity		7.2	8.3 ± 0.06
2,4/4,4		0.21	0.019 ± 0.001

*Trademark of The Dow Chemical Company

EXAMPLE 31

PREPARATION OF BISPHENOL F

5 Phenol and formaldehyde were reacted to produce bisphenol F. Similar results were obtained.

The preceding examples can be repeated with similar success by substituting the generically or specifically described reactants and/or operating conditions of this invention for those used in the preceding
 10 examples.

From the foregoing description, one skilled in the art can easily ascertain the essential characteristics of this invention and without departing from the spirit and scope thereof, can make various changes and modifications of the invention to adapt it to various usages and conditions.

Example 32

Alternate Preparation of a Representative [(Mercaptoalkyl)(Sulfo)-Phenylalkyl] Sulfonated Polystyrene Catalyst (Designated DPMSAA-0.25-1.5X2C)

A Preparation of (2-Bromoethyl)benzyl Chloride

(A1) In an extension of the procedure described by Selva, M; Trotta, F.; and Tundo, P. *Synthesis*, 1991, 1003-1004, (2-bromoethyl)benzylchloride was prepared by the following procedure:

Concentrated sulfuric acid (132 mL) was slowly added to ice cold deionized water (66 mL) in a 1 L three-necked glass reactor fitted with a mechanical stirrer, reflux condenser, and temperature probe. The reactor containing the sulfuric acid solution was cooled in an ice bath, then (2-bromoethyl)benzene (92.5 g, 0.50 mol) was added followed by 50 percent tetrabutylammonium chloride in water (10 g of solution), paraformaldehyde (20.0g, 0.666 mol, 1.33 equivalents), and finally sodium chloride (80.0 g, 1.37 mol, 2.74 equivalents). The slurry was stirred at approximately 1000 rpm (very vigorous) and heated to 80°C for 2.25 hours. The reaction was less than 50 percent complete as determined by gas chromatographic analysis. Additional paraformaldehyde (20.0 g, 0.666 mol, 1.33 equivalents) was added and the mixture was stirred (600-700 rpm) an additional 3.5 hours at 80°C. The reaction was approximately 50 percent complete as determined by gas chromatographic analysis. The mixture was allowed to cool and was transferred to a separatory funnel. The organic phase was separated and saved for further reaction.

(A2) Alternatively, (2-Bromoethyl)benzene (92.5 g, 0.50 mol), concentrated (12 molar) hydrochloric acid (125 mL, 1.5 mole HCl, 3 equivalents HCl), and paraformaldehyde (22.5 g, 0.75 mol, 1.5 equivalents) were added to a 1 L three-necked glass reactor fitted with a mechanical stirrer, addition funnel, and temperature probe. Concentrated sulfuric acid (111 mL, approximately 205 g, approximately 4 equivalents of sulfuric acid) was added to the addition funnel. A small portion (approximately 10-15 mL) of the sulfuric acid was added to the reaction mixture from the

addition funnel and the slurry was heated to 80°C with stirring at approximately 1000 rpm. After the reaction reaches 80°C, the remaining concentrated sulfuric acid was added dropwise over 3 hours. After an addition 1 hour reaction time, the reaction was less than 50 percent
5 complete as determined by gas chromatographic analysis. The mixture was allowed to cool and was transferred to a separatory funnel. The organic phase was separated and saved for further reaction.

The combined products from Example 32, parts A1 and A2 containing unreacted (2-bromoethyl)benzene and chloromethylated (2-bromoethyl)benzene
10 products (mixture of isomers) were further chloromethylated according to the procedure described in part A1. The reaction was performed using sufficient time and reagent (paraformaldehyde, sodium chloride, sulfuric acid) charges to completely consume the (2-bromoethyl)benzene starting material, giving a mixture of (2-bromoethyl)benzyl chloride isomers along
15 with higher-boiling by-products. The mixture of (2-bromoethyl)benzyl chloride isomers was isolated by oil-pump vacuum bulb-to-bulb Kugelrohr distillation (up to 140-145°C). The isolated product was a water-white oil which solidifies upon standing at room temperature. Gas chromatography analysis shows that unreacted (2-bromoethyl)benzene and the
20 higher boiling by-products were essentially absent from the distilled (2-bromoethyl)benzyl chloride isomers product.

B. Alkylation

Styrene/divinylbenzene co-polymer resin beads (10.00 g, -30+70 mesh, 1.5 percent divinylbenzene, approximately 96.0 mmole styrene repeat units)
25 were added to a round bottom glass flask (reactor) under a pad of nitrogen with a sodium hydroxide scrubber attached (to trap evolved HCl). A solution of (2-bromoethyl)benzyl chloride (mixture of aromatic ring isomers, predominately para) (10.0 g, 0.238 equivalents based upon styrene repeating units) in
30 1,2-dichloroethane (25 mL) was added to the dry resin beads. The beads were allowed to swell for approximately 5 to 10 minutes, then additional 1,2-dichloroethane (35 mL) was added to the swollen beads. Anhydrous tin(IV) chloride (2.5 mL, approximately 5.57 g, approximately 21.4 mmol) was slowly added via syringe to the polymer slurry at room temperature
35 over approximately 10 minutes with rapid stirring. The mixture turned light yellow when the tin(IV) chloride was added. The mixture was slowly warmed (in 5°C increments) to 40°C over approximately 30 minutes and was

allowed to react at 40°C for 1 hour. At this time the light orange mixture was slowly warmed (in 5°C increments) to 60°C over approximately 1 hour 30 minutes and was allowed to react overnight at 60°C with slow stirring. After overnight reaction, the mixture was cooled to room temperature and was quenched by slowly adding methanol to the well-stirred polymer slurry. The beads were separated from the solution using a glass-fritted funnel with vacuum filtration. The beads were sequentially washed (three portions each) with dichloromethane, water, tetrahydrofuran, and methanol, then the beads were dried overnight in a vacuum oven at 80°C (dry mass 13.89 g). Theoretical mass yield = 14.49 g. Alkylation yield (by mass uptake) = 87 percent. Approximate degree of polymer functionalization (by mass yield) = 0.21.

C. Sulfonation

The polymer beads from Example 32B (13.89 g, estimated 116 mmole of phenyl groups) were added to a glass reactor with addition funnel and NaOH scrubber attached. Dichloromethane (75 mL) was added to the flask and the beads were allowed to swell (rapid swelling was observed). The slurry was cooled to approximately 3 to 5 °C in an ice water bath. Chlorosulfonic acid (11.7 mL, approximately 20.5 g, approximately 176 mmol, approximately 1.5 equivalents per equivalent of phenyl groups) was slowly added dropwise over approximately 30 minutes to the cold polymer slurry with stirring. The mixture was allowed to react at approximately 3 to 5°C in an ice water bath for 1 hour. The mixture was removed from the ice bath and allowed to warm to room temperature over 2 hours 45 minutes. At this time, the polymer slurry was again cooled to 3-5°C in an ice water bath, and water was slowly added with rapid stirring to quench the excess chlorosulfonic acid. The beads were separated using a glass-fritted funnel with vacuum filtration. The beads were then washed extensively with water. Water was added to make a slurry, then solid sodium bicarbonate was slowly added in small portions with stirring until no more bubbling was observed (all active acid sites were neutralized). The beads were washed with water and transferred back to the glass reactor with 100 mL of water. The beads were then heated to 60 to 70°C over 2 hours to ensure hydrolysis of any residual sulfonyl chloride groups.

D. Thiolation

The aqueous polymer slurry from Example 32C (estimated approximately 20 mmole Br) was cooled to room temperature. Sodium bicarbonate was

slowly added until the slurry was neutral (no bubbling observed), then additional sodium bicarbonate (5.30 g, 63.0 mmol, approximately 3 equivalents relative to estimated bromine content in beads) was added to the aqueous bead slurry. Thiolacetic acid (4.5 mL, approximately 4.8 g, approximately 63 mmol, approximately 3 equivalents relative to estimated bromine content in beads) was added to an addition funnel. The reactor was evacuated and refilled with nitrogen several times to minimize the air content. The thiolacetic acid was slowly added over approximately 10-15 minutes to the aqueous bead slurry at room temperature with rapid stirring. The thiolacetic acid addition rate was adjusted to control the effervescent evolution of carbon dioxide which was formed in the neutralization process. After the thiolacetic acid addition was complete, the mixture was heated to 70°C and was allowed to react overnight with minimal stirring. The mixture was then cooled to room temperature and the beads were collected by filtration using a fritted-glass funnel. The beads were washed extensively with water, then with dichloromethane (optional), and then washed again with water. The beads were transferred back to the glass reactor, then concentrated (12 molar) hydrochloric acid (100 mL) was added. The mixture was heated with mild stirring to 50°C for 2-3 hours, then was cooled to room temperature. Deionized water (100 mL) was added and the beads were again collected by filtration using a fritted-glass funnel. The beads were washed with water, then were washed extensively (approximately 500 mL) with dilute (approximately 3 molar) aqueous hydrochloric acid. The beads were then washed again with deionized water and were transferred to a storage bottle without any additional drying. The final polymer catalyst has a titrated water-wet (water swollen) acid capacity of 0.80 milliequivalent/mL catalyst. The final polymer catalyst was designated as DPMSAA-0.25-1.5X2C

E. Preparation of DPMSAA Resin with 0.71 Equivalents Alkylation

Another mercaptosulfonic acid polymer was prepared from 1.5 percent crosslinked styrene/divinylbenzene co-polymer beads (-30+70 mesh) using the procedure described in steps B-D of Example 32, except using 0.71 equivalents of (2-bromoethyl)benzyl chloride in the alkylation reaction. Chlorosulfonic acid (2.0 equivalents relative to the calculated total equivalents of phenyl groups in the polymer) was used in the sulfonation reaction. Thiolacetic acid and sodium bicarbonate (3.0 equivalents of each reagent relative to the calculated amount of bromine in the polymer)

were used in the thiolation reaction. The mass yield of polymer obtained from the alkylation reaction corresponds to a 83 percent yield in the alkylation reaction and a degree of functionality of 0.59. The final polymer catalyst has a titrated water-wet (water swollen) acid capacity of 0.94 milliequivalent/mL catalyst. The final polymer catalyst was designated as DPMSAA-0.75-1.5X2C.

F. Preparation of DPMSAA Resin with 0.43 Equivalents Alkylation

Another mercaptosulfonic acid polymer was prepared from 1.5 percent crosslinked styrene/divinylbenzene co-polymer beads (-30+70 mesh) using the procedure described in steps B-D of Example 32, except using 0.43 equivalents of (2-bromoethyl)benzyl chloride in the alkylation reaction. Chlorosulfonic acid (2.0 equivalents relative to the calculated total equivalents of phenyl groups in the polymer) was in the sulfonation reaction. Thiolacetic acid and sodium bicarbonate (3.0 equivalents of each reagent relative to the calculated amount of bromine in the polymer) were used in the thiolation reaction. The mass yield of polymer obtained from the alkylation reaction corresponded to a 81 percent yield in the alkylation reaction and a degree of functionality of 0.35. The final polymer catalyst has a titrated water-wet (water swollen) acid capacity of 0.85 milliequivalent/mL catalyst. The final polymer catalyst was designated as DPMSAA-0.45-1.5X2C.

G. Preparation of DPMSAA with 0.095 Equivalents Alkylation

Another mercaptosulfonic acid polymer was prepared from 1.5 percent crosslinked styrene/divinylbenzene co-polymer beads (-30+70 mesh) using the procedure described in steps B-D of Example 32, except using 0.095 equivalents of (2-bromoethyl)benzyl chloride in the alkylation reaction. Chlorosulfonic acid (1.5 equivalents relative to the calculated total equivalents of phenyl groups in the polymer) was used in the sulfonation reaction. Thiolacetic acid and sodium bicarbonate (3.0 equivalents of each reagent relative to the calculated amount of bromine in the polymer) were used in the thiolation reaction. The mass yield of polymer obtained from the alkylation reaction corresponds to a 99 percent yield in the alkylation reaction and a degree of functionality of 0.094. The final polymer catalyst has a titrated water-wet (water swollen) acid capacity of 0.80 milliequivalent/mL catalyst. The final polymer catalyst was designated as DPMSAA-0.10-1.5X2C.

H. Preparation of DPMSAA with 0.42 Equivalents of (2-Bromoethyl)benzylchloride Alkylation and 0.30 Equivalents of Benzyl Chloride Alkylation

Another mercaptosulfonic acid polymer was prepared from 1.5 percent crosslinked styrene/divinylbenzene co-polymer beads (-30+70 mesh) using the procedure described in steps B-D of Example 32, except using 0.42 equivalents of (2-bromoethyl)benzyl chloride and 0.30 equivalents of benzyl chloride in the alkylation reaction. Chlorosulfonic acid (2.0 equivalents relative to the calculated total equivalents of phenyl groups in the polymer) was used in the sulfonation reaction. Thiolacetic acid and sodium bicarbonate (3.0 equivalents of each reagent relative to the calculated amount of bromine in the polymer) were used in the thiolation reaction. The final polymer catalyst has a titrated water-wet (water swollen) acid capacity of 0.94 milliequivalent/mL catalyst. The final polymer catalyst was designated as DPMSAA-0.45/0.30-1.5X2C.

I. Preparation of DPMSAA Resin having 0.423 Equivalents Alkylation

Another mercaptosulfonic acid polymer was prepared from 1.5 percent crosslinked styrene/divinylbenzene co-polymer beads (-30+70 mesh) using the procedure of steps B-D of Example 32, except using 0.423 equivalents of (2-bromoethyl)benzyl chloride in the alkylation reaction and directly carrying the polymer slurry obtained from the alkylation reaction directly on to the sulfonation reaction without any quenching, isolation, or washing steps after the alkylation reaction. Chlorosulfonic acid (1.25 equivalents relative to the total equivalents of phenyl groups present in all reactants) was added directly to the polymer slurry after the alkylation reaction was complete. Workup and subsequent isolation of the product after sulfonation was as in Example 32, except that more extensive washing was required to remove soluble reaction by-products from the polymer slurry. Thiolacetic acid and sodium bicarbonate (3.0 equivalents of each reagent relative to the estimated maximum amount of bromine present in the polymer) were used in the thiolation reaction. The final polymer catalyst has a titrated water-wet (water swollen) acid capacity of 0.78 milliequivalent/mL catalyst. The final polymer catalyst was designated as DPMSAA-0.45NW-1.5X2C.

J. Preparation of DPMSAA Resin with 0.238 Equivalents Alkylation

Another mercaptosulfonic acid polymer was prepared from 1.5 percent crosslinked styrene/divinylbenzene co-polymer beads (-30+70 mesh) using a variation of the procedure described in Example 32. The alkylation and sulfonation reactions were performed in one step utilizing chlorosulfonic acid as the alkylation catalyst and sulfonation reagent.

Styrene/divinylbenzene co-polymer resin beads (10.00 g, -30+70 mesh, 1.5 percent divinylbenzene, approximately 96.0 mmol styrene repeat units) were added to a round bottom glass flask (reactor) under a pad of plant nitrogen with a sodium hydroxide scrubber attached (to trap evolved HCl). A solution of (2-bromoethyl)benzyl chloride (mixture of aromatic ring isomers, predominately para) (5.32 g, 0.238 equivalents based upon styrene repeat units) in 1,2-dichloroethane (25 mL) was added to the dry resin beads. The beads were allowed to swell for approximately 5 to 10 minutes, then additional 1,2-dichloroethane (35 mL) was added to the swollen beads. The slurry was cooled 2 to 3°C in an ice bath, then chlorosulfonic acid (12.0 mL, approximately 21.0 g, 1.5 equivalents based upon total equivalents of phenyl groups in the mixture) was added slowly dropwise over approximately 1 hour 45 minutes. The mixture was allowed to stir an additional 1 hour at 3 to 4°C, then was removed to room temperature and allowed to react an additional 1.5 hours. The mixture was then cooled in an ice water bath and water was slowly added to quench the excess chlorosulfonic acid. Thereafter the beads were isolated according to the procedure described in part C of Example 32. Likewise, the thiolation reaction was as in part D of Example 32 using thiolacetic acid and sodium bicarbonate (3.0 equivalents of each reagent relative to the estimated maximum amount of bromine in the polymer). The final polymer catalyst has a titrated water-wet (water swollen) acid capacity of 0.94 milliequivalent/mL catalyst. The final polymer catalyst was designated as DPMSAA-2S-0.25-1.5X2C.

K. Preparation of DPMSAA Resin Having 6.5 percent Crosslinking

Another mercaptosulfonic acid polymer was prepared from 6.5 percent crosslinked styrene/divinylbenzene co-polymer beads (380 micron uniform particle size spheres) using the procedure described in steps B to D of Example 32, except using 0.427 equivalents of (2-bromoethyl)benzyl chloride in the alkylation reaction.

Chlorosulfonic acid (1.5 equivalents relative to the calculated total equivalents of phenyl groups in the polymer) was used in the sulfonation reaction. Thiolacetic acid and sodium bicarbonate (3.0 equivalents of each reagent relative to the calculated amount of bromine in the polymer) were used in the thiolation reaction. The mass yield of polymer obtained from the alkylation reaction corresponded to a 57 percent yield in the alkylation reaction and a degree of functionality of 0.24. The final polymer catalyst has a titrated water-wet (water swollen) acid capacity of 1.75 milliequivalent/mL catalyst. The final polymer catalyst was designated as DPMSAA-0.45-6.5X2C.

L. Preparation of DPMSAA Resin with 0.25 Equivalents Alkylation and Having 1.8 percent Crosslinking

Another mercaptosulfonic acid polymer was prepared from 1.8 percent crosslinked styrene/divinylbenzene copolymer beads (-25+40 mesh) using the procedure described in steps B through D of Example 32, except using 0.25 equivalents of (2-bromoethyl)benzyl chloride in the alkylation reaction.

Chlorosulfonic acid (1.5 equivalents relative to the calculated total equivalents of phenyl groups in the polymer) was used in the sulfonation reaction. Thiolacetic acid and sodium bicarbonate (3.0 equivalents of each reagent relative to the calculated amount of bromine in the polymer) were used in the thiolation reaction. The mass yield of polymer obtained from the alkylation reaction corresponds to an 86 percent yield in the alkylation reaction and a degree of functionality of 0.22. The final polymer catalyst had a titrated water-wet (water swollen) acid capacity of 0.85 milliequivalent/mL catalyst. The final polymer catalyst was designated as DPMSAA-0.25-1.8X2C.

M. Preparation of DPMSAA Resin with 0.10 Equivalents Alkylation and Having 1.8 percent Crosslinking

Another mercaptosulfonic acid polymer was prepared from 1.8 percent crosslinked styrene/divinylbenzene co-polymer beads (-25+40 mesh) using the procedure described in steps B to D of Example 32, except using 0.10 equivalents of (2-bromoethyl)benzyl chloride in the alkylation reaction. Chlorosulfonic acid (1.5 equivalents relative to the calculated total equivalents of phenyl groups in the polymer) was used in the sulfonation reaction. Thiolacetic acid and sodium bicarbonate (3.0 equivalents of each reagent relative to the calculated amount of bromine in the polymer) were used in the thiolation reaction. The final polymer catalyst has a

titrated water-wet (water swollen) acid capacity of 0.81 milliequivalent/mL catalyst. The final polymer catalyst was designated as DPMSAA-0.10-1.8X2C.

N. Preparation of 1.5 percent Crosslinked DPMSAA Resin with 0.10
5 Equivalents Alkylation and Using Sodium Hydrosulfide in the Thiolation Reaction

Another mercaptosulfonic acid polymer was prepared from 1.5 percent crosslinked styrene/divinylbenzene co-polymer beads (-30+70 mesh) using a variation of the procedure described in steps B to D of Example 32, except
10 using 0.10 equivalents of (2-bromoethyl)benzyl chloride in the alkylation reaction and sodium hydrosulfide in the thiolation reaction. Chlorosulfonic acid (1.5 equivalents relative to the calculated total equivalents of phenyl groups in the polymer) was used in the sulfonation reaction. Sodium hydrosulfide (6.4 equivalents relative to the calculated
15 amount of bromine in the polymer) was used in the thiolation reaction. The mass yield of polymer obtained from the alkylation reaction corresponds to a degree of functionality of 0.10. The final polymer catalyst has a titrated water-wet (water swollen) acid capacity of 0.82 milliequivalent/mL catalyst. The final polymer catalyst was designated as
20 DPMSAA-AT-0.10-1.5X2C.

O. Preparation of DPMSAA Resin with 0.25 Equivalents Alkylation and Having 4 percent Crosslinking

Another mercaptosulfonic acid polymer was prepared from 4 percent crosslinked styrene/divinylbenzene co-polymer beads (360 micron uniform
25 particle size spheres) using the procedure described in steps B-D of Example 32, except using 0.25 equivalents of (2-bromoethyl)benzyl chloride in the alkylation reaction. Chlorosulfonic acid (1.5 equivalents relative to the calculated total equivalents of phenyl groups in the polymer) was used in the sulfonation reaction. Thiolacetic acid and
30 sodium bicarbonate (3.0 equivalents of each reagent relative to the calculated amount of bromine in the polymer) were used in the thiolation reaction. The mass yield of polymer obtained from the alkylation reaction corresponds to a 73 percent yield in the alkylation reaction and a degree of functionality of 0.18. The final polymer catalyst was designated as
35 DPMSAA-0.25-4X2C.

P. Preparation of DPMSAA Resin with 0.10 Equivalents Alkylation and Having 4 percent Crosslinking

Another mercaptosulfonic acid polymer was prepared from 4 percent crosslinked styrene/divinylbenzene co-polymer beads (360 micron uniform particle size spheres) using the procedure described in steps B-D of Example 32, except using 0.10 equivalents of (2-bromoethyl)benzyl chloride in the alkylation reaction. Chlorosulfonic acid (1.5 equivalents relative to the calculated total equivalents of phenyl groups in the polymer) was used in the sulfonation reaction. Thiolacetic acid and sodium bicarbonate (3.0 equivalents of each reagent relative to the calculated amount of bromine in the polymer) were used in the thiolation reaction. The mass yield of polymer obtained from the alkylation reaction corresponds to an 74 percent yield in the alkylation reaction and a degree of functionality of 0.074. The final polymer catalyst was designated as DPMSAA-0.10-4X2C.

Example 33

Evaluation of Catalysts in a Continuous Process

A three-stage up-flow reactor was constructed from three vertical stainless steel tubes with sampling ports between each section. Each reactor stage was water jacketed for temperature control with all connecting lines heat-traced to prevent reactor line plugging. Likewise the 2L reactor feed tank was jacketed so that precise control of the reactor feed can be obtained. From the feed tank, feed flows through an electrically heat-traced section of tubing for control of feed input temperature.

Each reactor section was packed with 10-20 mL of water-wet catalyst.

The reactor feed consists of a solution of 4 weight percent acetone in phenol. The acetone:phenol mixture was precisely metered into the temperature controlled reactor system at a defined combination of flow rate (1.0 mL/min to 2.0 mL/min) and reactor temperature (55°C to 65°C). Upon start-up of each new loading of catalyst, the feed passes through the catalyst for at least 12 hours before measurements were recorded to remove water from the catalyst. Product composition of the reactor effluent from each of the three stages was analyzed by HPLC while gas chromatography was used to analyze for acetone and water. The results obtained from tests of the catalysts at various times of reaction (reactor residence times) were provided in Table XIX. Productivity was expressed in terms of pounds of bisphenol A produced per hour per cubic foot of water-swollen catalyst charged into the reactor. (NOTE: Unless otherwise noted, all of the catalyst results were obtained at 55°C.)

Table XIX

CATALYST	Res. Time	Acetone Conv. (%)	Prod. lb/hr/ft ³	op/pp (%)	tris/pp (%)	Cyclics/pp (%)	tot imp/pp (%)
65 C DOWEX 50Wx4, 25% Prom.	10	61.47%	18.03	2.524%	0.702%	0.535%	5.393%
	20	77.69%	11.53	2.722%	0.648%	0.472%	5.204%
	30	84.52%	8.34	2.826%	0.628%	0.455%	5.149%
55 C DOWEX 50Wx4, 25% Prom.	10	49.28%	13.83	1.983%	0.783%	0.328%	5.297%
	20	66.16%	9.51	2.102%	0.675%	0.292%	4.862%
	30	73.02%	7.06	2.163%	0.692%	0.257%	4.838%
DPMSA-MER3C	5	84.28%	49.76	1.479%	0.549%	0.879%	5.053%
	10	97.63%	29.92	1.456%	0.491%	0.828%	3.829%
	15	100.00%	20.62	1.449%	0.553%	0.836%	3.831%
DPMSA-1.5X3C	7.5	46.34%	18.12	1.884%	0.855%	0.929%	5.803%
	15	71.71%	14.51	1.769%	0.794%	0.890%	4.359%
	22.5	81.41%	11.21	1.733%	0.730%	0.819%	4.951%
DPMSA-1.5X2C	7.5	44.74%	16.13	1.577%	0.958%	1.524%	7.512%
	15	74.84%	14.31	1.537%	0.800%	1.298%	4.840%
	22.5	88.14%	11.53	1.534%	0.790%	1.167%	5.372%
DPMSA-6/42-3C	7.5	11.34%	3.08	2.519%	0.000%	2.096%	12.918%
	15	29.62%	4.38	2.203%	0.383%	2.044%	15.295%
	22.5	52.79%	6.12	1.946%	0.296%	1.999%	12.032%
DPMSA-6.5X3C	7.5	1.68%	0.13	0.000%	3.029%	0.000%	1.290%
	15	1.11%	0.05	0.000%	2.166%	0.000%	2.166%
	22.5	0.34%	0.10	0.524%	0.687%	0.000%	0.671%
DPMSAA-0.75-1.5X2C	7.5	90.84%	34.65	1.583%	0.992%	0.570%	4.298%
(0.75 funct.)	15	98.43%	20.02	1.596%	0.912%	0.513%	3.707%
	22.5	100.00%	13.30	1.521%	0.922%	0.677%	3.478%
DPMSAA-0.75-1.5X2C (2 ML)	3.75	66.83%	51.95	1.571%	0.886%	0.687%	5.074%
	7.5	89.68%	35.41	1.590%	0.975%	0.565%	4.400%
	11.25	94.95%	25.26	1.617%	0.945%	0.528%	4.142%
DPMSAA-0.45-1.5X2C	7.5	88.41%	35.33	1.500%	0.948%	0.454%	3.972%
	15	96.92%	20.14	1.615%	0.896%	0.381%	3.481%
	22.5	100.00%	13.61	1.807%	0.894%	0.416%	3.549%
DPMSAA-0.45-1.5X2C (2 ML)	3.75	62.82%	51.50	1.533%	1.030%	0.523%	4.535%
	7.5	87.35%	35.25	1.542%	0.942%	0.448%	4.101%
	11.25	94.30%	25.66	1.571%	0.915%	0.414%	3.793%
DPMSAA-0.45/0.30-1.5X2C (2 ML)	2.5	57.60%	66.41	1.480%	0.902%	0.709%	4.875%
	5	77.51%	44.63	1.530%	0.883%	0.683%	4.540%
	7.5	87.41%	34.38	1.520%	0.846%	0.600%	4.208%
DPMSAA-0.45NW-1.5X2C	3.75	63.00%	54.30	1.501%	0.824%	0.693%	4.538%
(2 ML)	7.5	84.20%	36.13	1.531%	0.808%	0.610%	4.034%
	11.25	93.44%	26.46	1.578%	0.802%	0.539%	3.707%
DPMSAA-0.25-1.5X2C	3.75	67.68%	52.61	1.565%	0.952%	0.399%	4.190%
(2 ML)	7.5	85.79%	33.77	1.552%	0.873%	0.405%	3.725%
	11.25	92.42%	24.34	1.623%	0.862%	0.412%	3.601%
DPMSAA-0.10-1.5X2C	3.75	59.7%	50.28	1.666%	0.828%	0.267%	3.790%
(2mL)	7.5	77.5%	32.51	1.660%	0.801%	0.330%	3.580%
	11.25	85.64%	24.05	1.670%	0.777%	0.315%	3.440%

Note: "2 ML" means flow was 2
ml/min - otherwise flow was 1 ml/min

% was percent

conv. was conversion

prod. was product Bisphenol A

op/pp was the ratio of ortho, para bisphenol to para, parabisphenol tris was higher
oligomeric adduct derived from the reaction of 2 acetone molecules with 3 phenol molecules
cyclics were by-products having dianins, spirobiindanols, and dihydroindanols.

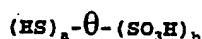
tot. imp. was total impurities including ortho, para bisphenol A, tris, cyclics as well as

10 other unidentified product peaks.

WHAT IS CLAIMED IS:

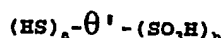
1. A process for the condensation of an aldehyde or ketone starting material with a phenol, unsubstituted in at least one position, wherein the aldehyde or ketone starting material is reacted with the phenol in a reaction mixture in the presence of a soluble or insoluble mercaptosulfonic acid compound under conditions sufficient to bring about formation of a geminal bisphenolic moiety at each aldehyde or ketone moiety in the starting material;

provided that the soluble mercaptosulfonic acid compound was characterized by the formula



wherein θ was an alkylene, cycloaliphatic, arylene, alkylenearylene, alkylenecycloaliphatic, alkylenearyl, heterocyclic or alkyleneheterocyclic residue and a and b were independently selected from integers from 1 to 20; and

the insoluble mercaptosulfonic acid comprises a catalytically-active species represented by the formula



20



in which θ' was an alkylene, cycloaliphatic, arylene, alkylenearylene, alkylenecycloaliphatic, alkylenearyl, heterocyclic or alkyleneheterocyclic residue; a and b were independently selected from integers from 1 to 20; L was an optional linking group and - was a bond, which catalytically-active species was attached by the bond - to an insoluble organic or inorganic support;

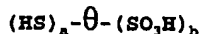
or a catalytically-active species represented by the unit formula



wherein θ'' was an alkylene, arylene, cycloaliphatic, alkylenearylene, alkylenecycloaliphatic, alkylenearyl, heterocyclic or alkyleneheterocyclic residue; a and b were independently selected from integers from 1 to 20; L' was an optional linking group and - was a bond, wherein the mercaptosulfonic acid catalyzes isomerization of crude product mixture to

produce more bis-(4-hydroxyphenyl) compound than would be produced without isomerization..

2. The process of Claim 1, wherein the mercaptosulfonic acid compound was soluble in the reaction mixture and was characterized by the
5 formula



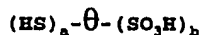
wherein θ was an alkylene, cycloaliphatic, arylene, alkylenearylene, alkylenecycloaliphatic, alkylenearyl, heterocyclic or alkyleneheterocyclic residue and a and b were independently selected from integers from 1 to
10 10, wherein the mercaptosulfonic acid catalyzes isomerization of crude product mixture to produce more bis-(4-hydroxyphenyl) compound than would be produced without isomerization.

3. The process of Claim 1, wherein the ketone was fluorenone, the phenol was unsubstituted and the product was 9,9-bis-(4-
15 hydroxyphenyl)fluorene, wherein the mercaptosulfonic acid catalyzes isomerization of crude product mixture to produce more bis-(4-hydroxyphenyl) compound than would be produced without isomerization.

4. The process of Claim 2, comprising a process for making a bisphenol by the step of contacting an aldehyde or a ketone with excess
20 phenolic compound in the presence of a catalytic amount of mercaptosulfonic acid catalyst, which was soluble in the reaction mixture, at a temperature selected such that a bisphenol was formed and crystallizes in the reaction mixture, wherein the mercaptosulfonic acid catalyzes isomerization of crude product mixture to produce more bis-(4-
25 hydroxyphenyl) compound than would be produced without isomerization.

5. The process of Claim 4, wherein the ketone was acetone, the phenolic compound was phenol, and the bisphenol was bisphenol A, wherein the mercaptosulfonic acid catalyzes isomerization of crude product mixture to produce more bis-(4-hydroxyphenyl) compound than would be produced
30 without isomerization..

6. The process of Claim 1, wherein the catalyst was represented by the formula



wherein θ was an alkylene, cycloaliphatic, arylene, alkylenearylene, alkylene-cycloaliphatic, alkylene-aryl, heterocyclic, or alkylene-heterocyclic moiety, and a and b were each independently integers averaging from 1 to 4, wherein the mercaptosulfonic acid catalyzes
35

isomerization of crude product mixture to produce more bis-(4-hydroxyphenyl) compound than would be produced without isomerization..

7. The process of Claim 6, wherein the catalyst was represented by the formula



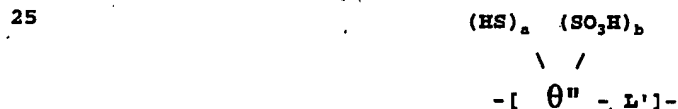
wherein θ was an alkylene, cycloalkylene or arylene moiety having from 2 to 10 carbon atoms, wherein the mercaptosulfonic acid catalyzes isomerization of crude product mixture to produce more bis-(4-hydroxyphenyl) compound than would be produced without isomerization.

8. The process of Claim 1, wherein the mercaptosulfonic acid was an insoluble material comprising a catalytically-active species represented by the formula



in which θ' was an alkylene, cycloaliphatic, arylene, alkylenearylene, alkylenecycloaliphatic, alkylenearyl, heterocyclic or alkyleneheterocyclic residue; a and b were independently selected from integers from 1 to 20; L was an optional linking group and - was a bond, which catalytically-active species was attached by the bond - to an insoluble organic or inorganic support;

or a catalytically-active species represented by the unit formula



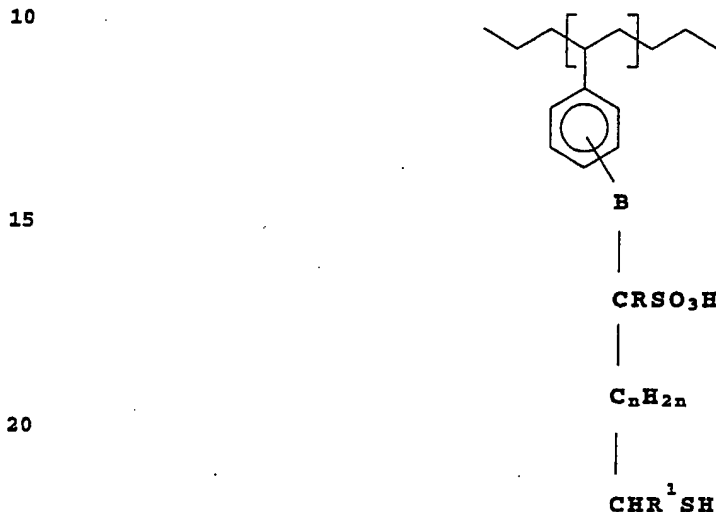
wherein θ'' was an alkylene, arylene, cycloaliphatic, alkylenearylene, alkylenecycloaliphatic, alkylenearyl, heterocyclic or alkyleneheterocyclic residue; a and b were independently selected from integers from 1 to 5; L' was an optional linking group and - was a bond, wherein the mercaptosulfonic acid catalyzes isomerization of crude product mixture to produce more bis-(4-hydroxyphenyl) compound than would be produced without isomerization.

9. The process of Claim 8, wherein the catalytically-active species was attached to the backbone of a polymer from at least one ethylenic monomer, wherein the mercaptosulfonic acid catalyzes

isomerization of crude product mixture to produce more bis-(4-hydroxyphenyl) compound than would be produced without isomerization..

10. The process of Claim 8, wherein the catalytically-active species was incorporated in a polystyrene resin, wherein the
5 mercaptosulfonic acid catalyzes isomerization of crude product mixture to produce more bis-(4-hydroxyphenyl) compound than would be produced without isomerization..

11. The process of Claim 10, wherein the polystyrene resin includes unit structures represented by the formula



wherein B was a bridging group, R and R¹ were independently selected from
25 H, alkyl and aryl, -C_nH_{2n}- was straight or branched chain alkylene and n was an integer from 0 to 20, wherein the mercaptosulfonic acid catalyzes isomerization of crude product mixture to produce more bis-(4-hydroxyphenyl) compound than would be produced without isomerization.

12. The process of Claim 10, wherein the polystyrene resin was
30 made by the steps of

(a) treating polystyrene with an alkenyl halide of the formula
RC(R¹)=C(R²)C_mH_{2m}CH(R³)X, wherein R, R¹, R² and R³ were independently
selected from H, alkyl or aryl; X was selected from F, Cl, Br or I and m
was 0 to 10; to produce a haloalkylpolystyrene;

35 (b) sulfonating the resulting haloalkylpolystyrene to produce a sulfo(haloalkyl)polystyrene,

(c) optionally converting the sulfo function to an alkali metal or alkaline earth metal salt,

(d) reacting the halo function with a reactive thiolate to produce a corresponding mercaptan function and

5 (e) optionally acidifying to produce a corresponding sulfonic acid function,

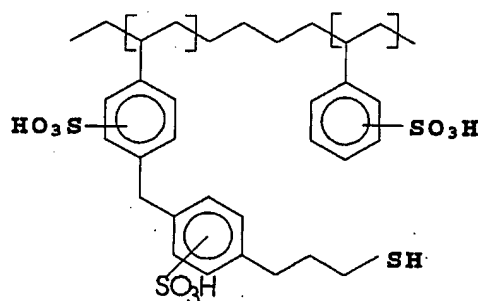
(f) isomerizating crude product mixture to produce more bis-(4-hydroxyphenyl) compound than would be produced without isomerization in the presence of the mercaptosulfonic acid.

10 13. The process of Claim 12, wherein the alkenyl halide was an allyl halide of the formula $RC(R^1)=C(R^2)CH(R^3)X$, wherein each of R, R^1 , R^2 and R^3 was H independently H or alkyl of 1-5 carbon atoms.

14. The process of Claim 10, wherein the polystyrene resin includes unit structures represented by the formula

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20



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wherein the mercaptosulfonic acid catalyzes isomerization of crude product mixture to produce more bis-(4-hydroxyphenyl) compound than would be produced without isomerization.

30 15. The process of Claim 10, wherein the polystyrene resin was made by the steps of:

(a) alkylating a haloalkylated polystyrene with a haloalkylarylene compound to produce an intermediate having [(haloalkyl)phenylalkyl] styrene units;

35 (b) sulfonating the thus-produced intermediate to produce an intermediate containing [(haloalkyl)(sulfo)phenylalkyl] sulfostyrene units;

(c) optionally converting the sulfo functions to corresponding alkali metal salts;

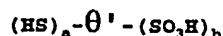
(d) thiolating the thus-produced intermediate which contained sulfostyrene units;

5 (e) and hydrolyzing the thus-thiolated intermediate with an acid to produce a polymer containing [(mercaptoalkyl)(sulfo)-phenylalkyl] sulfopolystyrene units.

16. The process of Claim 10, wherein the polystyrene resin was made by the steps of (a) reacting a haloalkystyrene polymer with a
10 lithiated sultone, (b) treating a resulting sultone-functionalized polymer with a reactive thiolate and (c) acidifying the resulting intermediate to produce a polymer containing (mercaptosulfoalkyl)styrene units.

17. A process to make a bisphenol, wherein an aldehyde or a ketone is contacted with excess phenolic compound in the presence of a catalytic
15 amount of a mercaptosulfonic acid catalyst, which was soluble in the reaction mixture, at a temperature selected such that a bisphenol was formed and crystallizes in the reaction mixture and wherein the mercaptosulfonic acid catalyzes isomerization of crude product mixture to produce more bis-(4-hydroxyphenyl) compound than would be produced without
20 isomerization.

18. The process of Claim 15, wherein the catalyst was represented by the formula:



25 wherein θ was an alkylene, cycloaliphatic, arylene, alkylene-arylene, alkylene-cycloaliphatic, alkylene-aryl, heterocyclic, or alkylene-heterocyclic moiety, and a and b were each independently integers averaging from 1 to 4.

19. The process of Claim 15, wherein the mercaptosulfonic acid catalyzes isomerization of crude product mixture to produce more bis-(4-
30 hydroxyphenyl) compound than would be produced without isomerization.

20. A process of isomerizing an o,p-bisphenol to form a corresponding p,p-bisphenol wherein the o,p-bisphenol is contacted with a mercaptosulfonic acid at a temperature sufficient to result in isomerization of the o,p-bisphenol to form a p,p-bisphenol.



wherein θ was an alkylene, cycloaliphatic, arylene, alkylenearylene, alkylencycloaliphatic, alkylenearyl, heterocyclic or alkyleneheterocyclic residue and a and b were independently selected from integers from 1 to 20; and

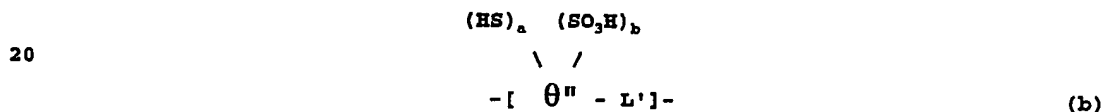
- 5 the insoluble mercaptosulfonic acid comprises a catalytically-active species represented by the formula



10

- in which θ' was an alkylene, cycloaliphatic, arylene, alkylenearylene, alkylencycloaliphatic, alkylenearyl, heterocyclic or alkyleneheterocyclic residue; a and b were independently selected from integers from 1 to 20; L
- 15 was an optional linking group and - was a bond, which catalytically-active species was attached by the bond - to an insoluble organic or inorganic support;

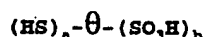
or a catalytically-active species represented by the unit formula



20

- wherein θ'' was an alkylene, arylene, cycloaliphatic, alkylenearylene, alkylencycloaliphatic, alkylenearyl, heterocyclic or alkyleneheterocyclic residue; a and b were independently selected from integers from 1 to 20;
- 25 L' was an optional linking group and - was a bond.

21. The process of Claim 20, wherein the mercaptosulfonic acid compound was soluble in the reaction mixture and was characterized by the formula



- 30 wherein θ was an alkylene, cycloaliphatic, arylene, alkylenearylene, alkylencycloaliphatic, alkylenearyl, heterocyclic or alkyleneheterocyclic residue and a and b were independently selected from integers from 1 to 10.

22. The process of Claim 20, wherein each of a and b were independently selected from integers from 1 to 4.
- 35

23. The process of Claim 20, wherein a and b were each 1.

24. The process of Claim 20, wherein the mercaptosulfonic acid compound was generated in the reaction mixture by reaction between an alkali metal salt of a mercaptosulfonic acid and a mineral acid.

25. The process of Claim 24, wherein the alkali metal salt of the mercaptosulfonic acid compound was generated in the reaction mixture by reaction between a mercaptosulfonate ester and an alkali metal hydroxide.

26. The process of Claim 22, wherein the mercaptosulfonic acid compound was generated in the reaction mixture by reaction between a mercaptosulfonyl halide and a mineral acid.

27. The process of Claim 21, wherein the mercaptosulfonic acid compound was a mercaptoalkanesulfonic acid of up to 20 atoms between the mercapto and sulfonic acid groups.

28. The process of Claim 21, wherein the mercaptosulfonic acid compound was 3-mercaptopropanesulfonic acid.

29. The process of Claim 21, wherein the mercaptosulfonic acid compound was 4-mercaptobutanesulfonic acid.

30. The process of Claim 21, wherein the mercaptosulfonic acid compound was 2-mercaptoethanesulfonic acid.

31. The process of Claim 21, wherein the mercaptosulfonic acid was free of or substantially free of chloride ions.

32. The process of Claim 20, carried out at a temperature from 15°C to 60°C.

33. The process of Claim 20, wherein the reaction mixture contained from 0.01 to 2.0 equivalent of mercaptosulfonic acid per mole of aldehyde or ketone.

34. The process of Claim 20, carried out with removal of water from the reaction mixture.

35. The process of Claim 20, wherein the reaction mixture contained from 0.02 to 1.0 equivalent of mercaptosulfonic acid per mole of aldehyde or ketone.

36. The process of Claim 20, wherein the ketone was fluorenone, the phenol was unsubstituted and the product was 9,9-bis-(4-hydroxyphenyl)fluorene.

37. The process of Claim 20, wherein the ketone was acetone, the phenol was unsubstituted and the product was 2,2-bis-(4-hydroxyphenyl)propane.

38. The process of Claim 20, wherein the ketone was 4-hydroxyacetophenone, the phenol was unsubstituted and the product was 1,1,1-tris-(4-hydroxyphenyl)ethane.

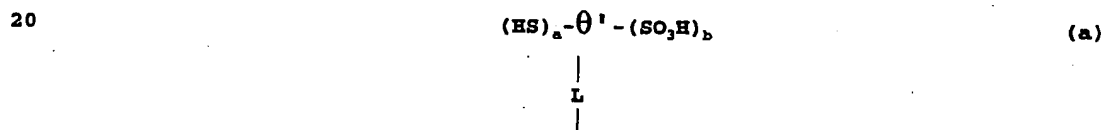
39. The process of Claim 20, wherein crude product, resulting from the condensation, was extracted with water to remove $(HS)_a-\theta-(SO_3H)_b$ from the product.

40. The process of Claim 20, wherein crude product, resulting from the condensation, was extracted with an aqueous solution of an alkali metal hydroxide, carbonate or bicarbonate to remove $(HS)_a-\theta-(SO_3H)_b$ from the product.

41. The process of Claim 20, wherein crude product, resulting from the condensation, was treated with an anion-exchange resin to remove $(HS)_a-\theta-(SO_3H)_b$ from the product.

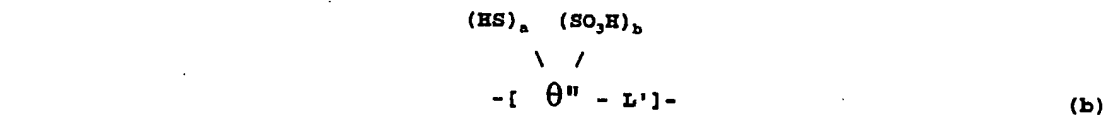
42. The process of Claim 39, wherein the resulting aqueous extract is further concentrated and the thus-concentrated solution of extracted $(HS)_a-\theta-(SO_3H)_b$ is recycled to the process.

43. The process of Claim 20, wherein the mercaptosulfonic acid was an insoluble material comprising a catalytically-active species represented by the formula



25 in which θ' was an alkylene, cycloaliphatic, arylene, alkylenearylene, alkylencycloaliphatic, alkylenearyl, heterocyclic or alkyleneheterocyclic residue; a and b were independently selected from integers from 1 to 20; L was an optional linking group and - was a bond, which catalytically-active species was attached by the bond - to an insoluble organic or inorganic support;

or a catalytically-active species represented by the unit formula

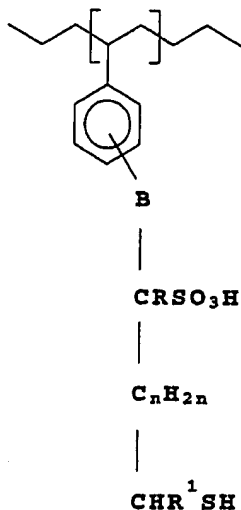


wherein θ'' was an alkylene, arylene, cycloaliphatic, alkylenearylene, alkylencycloaliphatic, alkylenearyl, heterocyclic or alkyleneheterocyclic residue; a and b were independently selected from integers from 1 to 5; L' was an optional linking group and - was a bond.

44. The process of Claim 43, wherein the catalytically-active species was attached to the backbone of a polymer from at least one ethylenic monomer.

45. The process of Claim 43, wherein the catalytically-active species was incorporated in a polystyrene resin.

46. The process of Claim 45, wherein the polystyrene resin includes unit structures represented by the formula



wherein B was a bridging group, R and R¹ were independently selected from H, alkyl and aryl, -C_nH_{2n}- was straight or branched chain alkylene and n was an integer from 0 to 20.

47. The process of Claim 46, wherein B was CH₂ and -C_nH_{2n}- was -CH₂CH₂- or -CH₂-.

48. The process of Claim 45, wherein the polystyrene resin was made by the steps of

(a) treating polystyrene with an alkenyl halide of the formula RC(R¹)=C(R²)C_mH_{2m}CH(R³)X, wherein R, R¹, R² and R³ were independently selected from H, alkyl or aryl; X was selected from F, Cl, Br or I and m was 0 to 10; to produce a haloalkylpolystyrene;

(b) sulfonating the resulting haloalkylpolystyrene to produce a sulfo(haloalkyl)polystyrene,

(c) optionally converting the sulfo function to an alkali metal or alkaline earth metal salt,

(d) reacting the halo function with a reactive thiolate to produce a corresponding mercaptan function and

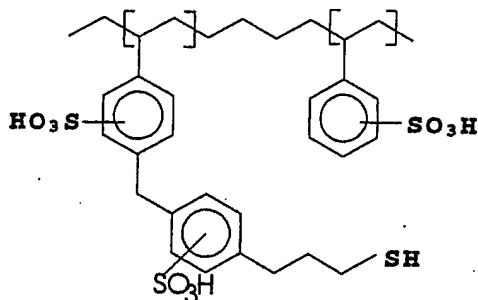
(e) optionally acidifying to produce a corresponding sulfonic acid function.

49. The process of Claim 48, wherein the alkenyl halide was an allyl halide of the formula $RC(R^1)=C(R^2)CH(R^3)X$, wherein each of R, R^1 , R^2 and R^3 was H independently H or alkyl of 1 to 5 carbon atoms.

50. The process of Claim 49, wherein each of R, R^1 and R^2 was H.

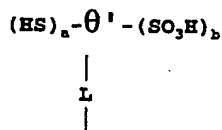
51. The process of Claim 48, wherein the alkenyl halide was 5-bromo-1-pentene or 11-bromo-1-undecene.

52. The process of Claim 49, wherein the polystyrene resin includes unit structures represented by the formula



53. The process of Claim 49, wherein the ketone was fluorenone, the phenol was unsubstituted and the product was 9,9-bis-(4-hydroxyphenyl)fluorene.

54. A catalytically-active material characterized in that there is an insoluble organic or inorganic support in which is incorporated a mercaptosulfonic acid residue represented by the formula



in which θ' was an alkylene, cycloaliphatic, arylene, alkylenearylene, alkylenearyl, heterocyclic or alkyleneheterocyclic residue; a and b were independently selected from integers from 1 to 20; L was an optional

linking group and - was a bond, which catalytically-active species was attached by the bond - to the insoluble organic or inorganic support.

55. The process of Claim 20, carried out in a stainless steel reactor, wherein the corrosion rate of the stainless steel reactor was less than 0.00254 cm/year.

56. The process of Claim 31, carried out in a stainless steel reactor, wherein the corrosion rate of the stainless steel reactor was less than 0.00254 cm/year.

57. The process of Claim 20, carried out in the absence of a diluent, other than excess phenol.

58. The process of Claim 20, carried out in the presence of diphenylmethane as a diluent.

59. The process of Claim 43, including the further steps of separating the catalytically-active material from the mixture; washing the catalytically-active material with a mixture of phenol and aldehyde or ketone and recycling the thus-washed material to the process.

60. The process of Claim 20, carried out in a batch reactor.

61. The process of Claim 20, carried out in a continuous reactor.

62. The process of Claim 37, carried out in the presence of a diluent which forms an adduct with 2,2-bis-(4-hydroxy-phenyl)propane under conditions such that 2,2-bis-(4-hydroxy-phenyl)propane crystallizes in the reaction mixture.

63. The process of Claim 45, wherein the polystyrene resin was made by the steps of:

(a) alkylating a haloalkylated polystyrene with a haloalkylarylene compound to produce an intermediate having [(haloalkyl)phenylalkyl] styrene units;

(b) sulfonating the thus-produced intermediate to produce an intermediate containing [(haloalkyl)(sulfo)phenylalkyl] sulfostyrene units;

(c) optionally converting the sulfo-functions to corresponding alkali metal salts;

(d) thiolating the thus-produced intermediate which contained sulfostyrene units;

(e) and hydrolyzing the thus-thiolated intermediate with an acid to produce a polymer containing [(mercaptoalkyl)(sulfo)-phenylalkyl] sulfopolystyrene units.

64. The process of Claim 63, wherein the haloalkylarylene compound was selected from chlorobenzene, chloromethylbenzene, chloroethylbenzene, chloropropylbenzene, chlorobutylbenzene or corresponding fluoro, bromo or iodo analogues.

5 65. The process of Claim 64, wherein the haloalkylarylene compound was selected from bromobenzene, bromomethylbenzene, bromoethylbenzene, bromopropylbenzene or bromobutylbenzene.

10 66. The process of Claim 45, wherein the polystyrene resin was made by the steps of (a) reacting a haloalkylstyrene polymer with a lithiated sultone, (b) treating a resulting sultone-functionalized polymer with a reactive thiolate and (c) acidifying the resulting intermediate to produce a polymer containing (mercaptosulfoalkyl)styrene units.

67. The process of Claim 66, wherein the lithiated sultone was a lithiated 1,3-propanesultone.

15 68. The process of Claim 66, wherein the lithiated sultone was a lithiated 1,4-butanedisultone.

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US96/13683

A. CLASSIFICATION OF SUBJECT MATTER

IPC(6) : C07C 39/16

US CL : 568/727, 728, 722, 723, 717

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

U.S. : 568/727, 728, 722, 723, 717

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

APS, CAS ONLINE

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
P, X	US 5,463,140 A (WEHMEYER et al.) 31 October 1995, entire document.	1-68
A	US 2,923,744 A (SCRIABINE et al.) 02 February 1960, entire document.	1
A	US 4,675,458 A (RIEMANN et al.) 23 June 1987, entire document.	1
A	US 4,996,373 A (BOTTENBRUCH et al.) 26 February 1991, entire document.	1
A	US 5,248,838 A (MASSIRIO et al.) 28 September 1993, entire document.	1

☐ Further documents are listed in the continuation of Box C. ☐ See patent family annex.

* Special categories of cited documents:	* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
A document defining the general state of the art which is not considered to be of particular relevance	*X* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
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Date of the actual completion of the international search

19 NOVEMBER 1996

Date of mailing of the international search report

03 DEC 1996

Name and mailing address of the ISA/US
Commissioner of Patents and Trademarks
Box PCT
Washington, D.C. 20231

Facsimile No. (703) 305-3230

Authorized officer

SREENI PADMANABHAN

Telephone No. (703) 308-1235